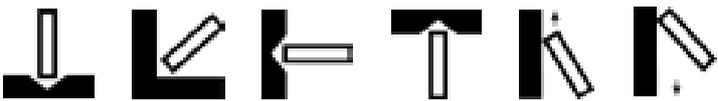


**Welding consumables GMAW solid wire electrode for:**  
**creep resistant steels**

**WDI Mo SG • VDG Mo • WEKO Mo**

<b>Standard designation</b>	<b>DIN EN ISO 14341-A</b> <b>G2Mo / GMoSi</b>		<b>AWS A 5.28</b> <b>ER80 S-G</b>			
<b>Properties and application range</b>	Welding wire for MAG-welding of creep resistant steels and higher strength fine grained steels up to operation temperatures of 550°C.					
<b>Materials being suitable for welding</b>	DIN 17102 ..... StE 380, StE 420, WStE 380, WStE 420 DIN 17155 ..... 19 Mn 5 DIN 17175 ..... St 45.8 EN 10028-2 ..... P265GH, 16 Mo 3, P295GH, P355GH EN 10028-3 ..... P355N, P460N, P355NH, P460NH EN 10113-2 ..... S355N, S460N					
<b>Reference analysis (%)</b>	<b>C</b> 0,1	<b>Si</b> 0,6	<b>Mn</b> 1,2	<b>Mo</b> 0,5		
<b>Mechanical performance according to EN 1597-1</b>	post-weld heat treatment  <b>U</b> <b>U</b>	inert gas  <b>C</b> <b>M2</b>	yield strength N/mm <sup>2</sup>  <b>460</b> <b>460</b>	all-weld metal tensile strength N/mm <sup>2</sup>  <b>530</b> <b>530</b>	elongation (L <sub>0</sub> =5d <sub>0</sub> ) %  <b>20</b> <b>20</b>	energy absorbed ISO-V(Joule)  <b>80</b> <b>100</b>
<b>Welding position</b>						kind of current= + inert gas (EN 439) Argon mixed gas CO <sup>2</sup>
<b>Qualification tests and approvals</b> ① = Site Hamm ② = Site Rothenburg	① VDG Mo: TÜV, DB					
<b>Wire packaging</b>	Spooling types see from page 78  <b>wire diameter 0,8 - 1,6 mm</b> other dimensions on demand					

GMAW solid wire electrode

submerged welding

gas welding staves