


Welding consumables GMAW solid wire electrode for:
creep resistant steels

WDI Mo SG • VDG Mo • WEKO Mo

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

GMAW solid wire electrode

submerged welding

gas welding staves