

**International standards**

	<b>S = massive wire</b>	<b>T = bare rod</b>
Werkstoff Nr.	1.5424	
DIN 8575	SG Mo 2	WSG Mo
AWS SFA-5.28	ER 80 S-G	ER 80 S-G

**Approvals**

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**Application notes**

Low alloyed moly containing steel MIG/TIG wire for welding heat resistant steels for working temperatures up to 550°C. Preheating temperatures depend on the base material.

**Operating temperature**

20° C up to + 550° C

**Base materials**

1.7380	10CrMo9-10	1.7259	26CrMo7
1.7375	12CrMo9-10	1.7273	24CrMo10
1.7380	G-12CrMo9-10	1.7276	10CrMo11
1.7379	G-17CrMo9-10	1.7281	16CrMo9-3
1.8075	10CrSiMoV7		

**Mechanical properties of all-weld-metal with Gas: M 21 (typical values)**

<b>Tensile strength</b> R <sub>m</sub> N/mm <sup>2</sup>	<b>Yielding strength</b> R <sub>p0,2</sub> N/mm <sup>2</sup>	<b>Elongation</b> A <sub>5</sub> %	<b>Impact strength</b> ISO – V J at -40° C
620	340	24	100

**Weld metal analysis (typical, wt %)**

<b>C</b>	<b>Si</b>	<b>Mn</b>	<b>Mo</b>
0,10	0,6	1,1	0,5

**Gas types EN 439**

**S = massive wire**  
M2, M3, C1

**T = bare rod**  
I1

**Current**

	<b>= +</b>				<b>= -</b>				
Diameter mm	<b>0,8</b>	<b>1,0</b>	<b>1,2</b>	<b>1,6</b>	<b>1,6</b>	<b>2,0</b>	<b>2,4</b>	<b>3,2</b>	<b>4,0</b>
Welding amps (A) min.	80	120	180	250					
Welding amps (A) max.	130	190	250	320					

**coils, weight**

Rev. 000

B300 15 kg.

25 kg.