

Classifications

EN 12536	AWS A5.2	AWS A5.2M
O IV	R60-G	RM40-G

Characteristics and typical fields of application

Mo-alloyed gas welding rod recommended for mild steels and 0.5 % Mo alloyed steels. High viscous weld puddle. Easy to operate. Approved in long-term condition up to +500 °C service temperature.

Base materials

Creep resistant steels, same alloyed

16Mo3, S235JR-S275JR, S275N, S275M, P195GH-P295GH, P195TR1-P265TR1, P195TR2-P265TR2, GE200-GE240

ASTM A 29 Gr. 1013, 1016; A 106 Gr. C; A; A 182 Gr. F1; A 283 Gr. B, C; A 501 Gr. B; A 510 Gr. 1013; A 512 Gr. 1021, 1026; A 513 Gr. 1021, 1026; A 633 Gr. C; A 709 Gr. 36, 50; A 711 Gr. 1013

Typical analysis of the TIG rods (wt.-%)

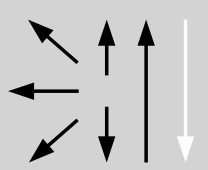
	C	Si	Mn	Mo
wt.-%	0.12	0.15	1.0	0.5

Mechanical properties of all-weld metal

Condition	Yield strength R _{p0,2}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work ISO-V KV J
	MPa	MPa	%	+20 °C
u	330 (≥ 295)	470 (≥ 400)	24 (≥ 20)	60 (≥ 39)

u untreated, as welded

Operating data

	Rod marking: front: ✦ O IV back: R60-G	ø (mm)
		2.0
		2.5
		3.2
		4.0

Preheating and post weld heat treatment as required by the base metal.

Approvals

TÜV (0146.), DB (70.014.03), SEPROZ, CE