MnMo

TOP FEATURES

- Low alloy steel wires with MnMo additions for welding high strength steels.

CLASSIFICATION

AWS A5.28	ER80S-D2 / ER90S-D2
EN ISO 636-B	W 57P 3U 4M31

SHIELDING GASES (ACC. EN ISO 14175)

I1	Inert gas Ar (100%)

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL

	C	Mn	Si	S	P	Ni	Mo	Cu
Typical	0.1	1.9	0.6	0.005	0.01	0.05	0.5	0.1

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	Tensile strength (MPa)	0.2% Proof strength (MPa)	Elongation 4d (%)	Impact ISO-V (J) -30°C	Hardness cap/mid
Min.			550	470	17	47	-
Typical values	I1	After PWHT	640	530	32	200	235/210

PWHT = Post Weld Heat Treament

- = not specified

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Weight (kg)	Item number
2.4	PE Tube	5.0	TMNMO-24

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:

Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.