

## CMo

## TIG (GTAW)

## 0.5%Mo TIG WIRE FOR CREEP RESISTING STEELS

## PRODUCT DESCRIPTION

0.5%Mo TIG wire for creep resisting steels

## CLASSIFICATIONS

AWS A5.28M ER70S-A1  
ISO 21952-A W Mo Si

## ASME IX QUALIFICATION

QW432 F-No 6  
QW442 A-No 2

## CHEMICAL COMPOSITION (WIRE WT %)

	C	Mn	Si	S	P	Cr	Mo	Ni	Cu	V
Min.	0.08	0.90	0.50	--	--	--	0.45	--	--	--
Max.	0.12	1.30	0.70	0.020	0.020	0.2	0.60	0.20	0.3	0.03
Typical	0.1	1.2	0.6	0.01	0.01	0.03	0.5	0.02	0.05	0.01

## ALL-WELD MECHANICAL PROPERTIES

Properties as-welded (AW) or PWHT:	Min.	Typical	
		AW	620°C/1h
Tensile strength (MPa)	515	662	640
0.2% proof strength (MPa)	400	540	520
Elongation (%) 4d	19	29	25
5d	22	26	24
Impact ISO-V(J) -30°C	--	52	170
Hardness HV	--	210/245	205/230

\*Minimum values are after PWHT 620°C/1h (AWS) and as-welded for ISO.

## TYPICAL OPERATING PARAMETERS

Shielding gas	Current	Diameter (mm)	Parameters
Argon	DC-	2.4	100A, 12V

## PACKAGING DATA

Diameter (mm)	Weight (kg)	Packaging	Item number
1.6	5	PE TUBE	TCMO-16
2.4	5	PE TUBE	TCMO-24

All information in this data sheet is accurate to the best of our knowledge at the time of printing. Please refer to [www.specialalloys.eu](http://www.specialalloys.eu) for any updated information.