Selectarc WELDING

SELECTARC MIG F61

Old reference : MIG 70SA1

Classification

AWS A5.28 : ER70S A1
ISO 14341-A : G 2 Mo

Material N° : 1.5124

Characteristics

GTAW rods for welding creep resisting steels (alloyed Mo) used at temperature upto 500°C. Good resistance to Hydrogen attacks (chemical installations). The weld deposit is highly resistant to cold cracking.

Applications

Steels and Pipes for Boiler and Pressure Vessels, Used for Piping systems of Boilers.

Base Materials

EN	P235G1TH - P255G1TH, P310GH
DIN	16Mo3 , L320 , L360NB-L415NB
ASTM	A335 Gr. P1 ; A352 Gr. LC1 ; A204 Gr. A ; A155 Gr. CM

Typical Weld Metal Composition (%)

C	Si	Mn	Mo	P	S	Fe
0.10	0.50	0.90	0.50	0.010	0.010	base

All Weld Metal Mechanical Properties (Typical)

Conditions	UTS Rm (MPa)	YS Re (MPa)	% Elg A_5	Impact (KV) Temp.°C	J
PWHT	590	485	25	-20	50

PWHT : After heat treatment at 650°C/1hr

Welding Current & Instructions

Welding Mode	Wire Ø (mm)	Welding Mode (A)	Welding Mode (V)	Shielding Gas ISO 14175
MIG	0.6	40 - 90	16 - 21	M21 (Ar/CO_2)
	0.8	60 - 100	18 - 21	C1 (100% CO_2)
= +	1.0	150 - 170	25 - 28	12 - 15 l/min
	1.2	170 - 220	26 - 28	
	1.6	180 - 270	26 - 32	

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