

MnMo

TIG (GTAW)

SOLID MnMo LOW ALLOYED WIRE FOR TIG WELDING OF WB36/P36 STEELS

PRODUCT DESCRIPTION

Solid MnMo low alloyed wire for TIG welding of WB36/P36 steels

CLASSIFICATIONS

AWS A5.28M

ER80S-D2, ER90S-D2

EN ISO 16834-B

4M31

EN ISO 14341-A

W 46 3 M G4Mo

EN ISO 14341

A 4Mo / B S4M31

440

[G4Mo]

APPROVALS

DNV

ASME IX QUALIFICATION

QW432

F-No 6

QW442

A-No 11

CHEMICAL COMPOSITION (WIRE WT %)

	C	Mn	Si	S	P	Ni	Mo	Cu
Min.	0.07	1.60	0.50	--	--	--	0.40	--
Max.	0.12	2.10	0.80	0.025	0.025	0.15	0.60	0.4
Typical	0.1	1.9	0.6	0.005	0.01	0.05	0.5	0.1

ALL-WELD MECHANICAL PROPERTIES

Properties after PWHT	Min.	Typical (590-620°C/1-2h)
Tensile strength (MPa)	550	640
0.2% proof strength (MPa)	470	530
Elongation [%] 4d	17	32
Impact ISO-V(J) -30°C	47	200
Hardness (HV) cap/mid	--	235/210

TYPICAL OPERATING PARAMETERS

Shielding gas	Current	Diameter (mm)	Parameters
Argon	DC-	2.4	120A, 14V

PACKAGING DATA

Diameter (mm)	Weight (kg)	Packaging	Item number
1.6	5	PE TUBE	TMNMO-16
2.0	5	PE TUBE	TMNMO-20
2.4	5	PE TUBE	TMNMO-24
3.2	5	PE TUBE	TMNMO-32