



AUTOTHERME Mn-Mo

CODIFICATION: AWS : SFA 5.28 ER80S-G

CHARACTERISTICS AND APPLICATIONS:

Autotherme Mn-Mo is a copper-coated solid wire for GMAW, available in bright finish, gives smooth flow, stable arc and spatter free under optimum welding conditions. It gives radiographic quality welds. It is suitable for welding high strength fine-grained structural steels containing ~ 0.5%Mo. The wire is also suitable for welding of penstock pipe-line, fabrication of earth moving equipments, etc. where high tensile strength property is desired from the weld metal. Suitable for welding of ASTM steels: SA-455/ SA-455M, Gr.60, Gr.65 steels of SA-515/ SA-515M, Gr.60, Gr.65 steels of SA-516/ SA-516M, Class 1 of A, B, C, D grades of SA-533/SA-533M, etc.

TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

Element	C	Mn	Si	S	P	Mo	Cu
%	0.06	1.75	0.53	0.010	0.015	0.40	0.15

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	YS (MPa)	Elongation (L=4d) %
640	540	23.0

WELDING PARAMETER: DC(+)

Diameter	Flat	
	Volt, V	Current, A
1.20 mm	27-32	300-360
1.60 mm	25-30	340-420

SHIELDING GAS: CO₂ / 80% Ar & 20 % CO₂

WELDING POSITION: H, F, VU, OH

PACKING:

STANDARD SIZE	1.2 mm & 1.6 mm.
QUANTITY	15.0 kg wire, layer wound in a plastic spool that conforms to DIN-8559 SD-300.

Note : Please check the availability and minimum order quantity before placing the order.