

FMn-Mo

CODIFICATION: **AWS :** SFA 5.28 ER80S-G

CHARACTERISTICS AND APPLICATIONS:

F Mn-Mo is a copper-coated solid wire for GTAW, 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	YS	Elongation
(MPa)	(MPa)	(L=4d) %
640	540	23.0

SHIELDING GAS: Argon

CURRENT CONDITION: DCEN

WELDING POSITION: H, F, VU, OH

PACKING :

STANDARD SIZE Diameter 1.6 mm, 2.0 mm, 2.4 mm & 3.2 mm in cut lengths of 500 mm / 1000 mm each.

QUANTITY 5 kg wire put in an air-tight polythene bag and finally packed in a plastic container.
 Identification AWS code is punched on each wire.