

**SG Mo****mild Steel MAG-Wire  
TIG-Rod****Specifications:**

Werkstoff Nr.: 1.5424  
DIN EN ISO 21952-A: G/W MoSi  
AWS-Bezeichnung: ER 80 SG

**Application:**

Particularly suitable for welding of steels resistant to hot creeps up to 550°C, to join pipes, boilers, equipments, rigs and tanks.  
High elastic limits.

**Chemical Composition  
Element by weight (%):**

C: 0,10 Si: 0,60 Mn: 1,10 Mo: 0,50

**Mechanical Properties:**

typical)

Yield Point(Re)	490 - 520 N/mm <sup>2</sup>
Tensile Strength (Rm)	560 - 650 N/mm <sup>2</sup>
Elongation (A)(Lo=5do)	> 22 %
Impact energy (Av)	> 80 J
High temp.	550°C
Low temp.	-40°C

**Approvals :**

TÜV, DB, CE-Zeichen

**Shielding Atmosphere:**

MSG-wire	C, M1, M2, M3
TIG-rods	I1 EN 439

**Typical Base Mat.:**

St 35.8, St 45.8,  
HI, HII, 17 Mn 14, 19 Mn 6, 15 Mo 3  
GS-C25, GS-22 Mo 4  
WStE 255 bis WStE 460  
TÜV-Kennblatt 1000: Gruppe 1-5 und 8-10  
ISO 20172: Gruppe 1.2 / 1.3 (ReH max 460N/mm<sup>2</sup>)  
ISO 20172: Gruppe 2.1  
ISO 20172: Gruppe 3.1 (ReH max 460N/mm<sup>2</sup>)

**Packaging:**

MIG/MAG: spools D 100 / D 200 / K 200 / K 300  
TIG: 25-kg-boxes  
the rods are marked with DT-SGMo