



Molyten S Plus

LOW ALLOY STEEL (High Temperature)

Special Welding Electrode for high temperature application.

CLASSIFICATION : EN 1599 AWS A/SFA 5.5
 E Mo B 32 H5 E 7018-A1

KEY FEATURES :

- Basic type heavy coating
- Excellent high temperature creep resistance properties
- Deposition efficiency of 105%
- Preheat and PWHT at 620°C is required
- Radiographic quality welds

WELDING POSITION : AC (70 OCV)/DCEP

TYPICAL APPLICATIONS :

- Welding 0.5 Mo and 1 Cr - 0.5 Mo steels and similar composition steels used in pressure vessels, boilers and pipelines
- Application in chemical, oil refining industries and turbine casting
- Suitable for 15Mo3, 16Mo3, 14Mo6
- Joining ASTM SA 182/182M Gr.F1

REDRYING CONDITION : 300°C for 1 hr. (Also available in vacuum packed condition)

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	Mo	S	P
Specification	0.05-0.09	0.90 max	0.25-0.55	0.40-0.65	0.015 max	0.015 max

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at 20°C, J
Specification	PWHT: 620°C for 1 hr.	600 min	470 min	22-28	27 min

Diffusible H2 Content: <5 ml/100 gm

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Approx. Pcs/Carton	Carton/Box	Approx. wt. of 1000 pcs, Kg.
2.5 x 350	60-90	250	4	20
3.15x 450	100-140	139	4	36
4.0 x 450	140-180	85	4	59
5.0 x 450	190-250	50	4	100

EQUIVALENT : GTAW filler: Tigfil-70S-A1