

IABCO A30 MIG

MIG/GMAW wire for mild and low alloy steels

Product name	IABCO ER70S-A1 MIG
Classification EN ISO	14341-A: G 2Mo / G 42 2 C1 2Mo / G 46 6 M21 2Mo 21952-A: G MoSi
Material No.	1.5424
Classification AWS	A5.28: ER70S-A1/ER80S-G
Approvals	TÜV 12687.00, CE.
Applications	MIG/GMAW wire for 0.5%Mo steels. These steels are commonly used at service temperatures up to 500°C and for some sub-zero structural applications. The 0.5% alloying improves creep performance compared to CMn steels and sees the alloy being used for boiler, pressure vessel and piping construction. The good general mechanical properties also ensures use in general structural engineering applications.
Base materials	For similar alloyed high temperature steels and cast steels, ageing resistant and steels resistant to caustic cracking. ASTM: A182/A336 grade F1, A204 grades A/B/C, A209/A250 grade T1, A217 grade WC1, A335 grade P1, A352 grade LC1. P235G1TH-P255G1TH, P310GH, L320, L360NB-L415NB, 16Mo3.
Typical analysis of wire, weight %	C: 0.10 Si: 0.60 Mn: 1.15 Mo: 0.52
Typical heat treatment ⁽¹⁾	Preheat temperature: Dependent on material thickness. Interpass temperature: 250°C. PWHT: AW or 650°C.
Mechanical properties of weld deposit ⁽²⁾	C1 shielding gas: 0.2% proof stress, Rp0.2%: ≥420MPa. Tensile strength, Rm: ≥500MPa. Elongation, 4d/5d: ≥20%. Impact ISO-V, -20°C: ≥47J. M21 shielding gas: 0.2% proof stress, Rp0.2%: ≥460MPa. Tensile strength, Rm: ≥530MPa. Elongation, 4d/5d:
Other products	SAW: S2Mo, S3Mo. TIG/GTAW: A30.

Notes (1) Application codes and project specifications should always be referred to for specific requirements.

(2) Actual mechanical properties will be dependent on specific welding procedure (including shielding gas, flux, PWHT etc) and should always be confirmed by approval of an appropriate welding procedure.