

IABCO A30 TIG

TIG/GTAW wire for mild and low alloy steels

Product name	IABCO A30 TIG
Classification EN ISO	636-A: W 46 4 2Mo 21952-A: W MoSi
Material No.	1.5424
Classification AWS	A5.28: ER70S-A1 ER80S-G
Approvals	TÜV 12688.0, CE.
Applications	TIG/GTAWRod 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. A182/A336 F1, A204 grades A/B/C, A209/A250 T1, A217 WC1, A335 P1, A352 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 610-650°C.
Mechanical properties of weld deposit ⁽²⁾	0.2% proof stress Rp0.2%: ≥460MPa. Tensile strength Rm: ≥550MPa. Elongation 4d/5d: ≥19/22%. Impact ISO-V, -40°C: ≥47J.
Other products	SAW: S2Mo, S3Mo. MIG/GMAW: 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.