

TALARC A1 Mo

CLASSIFICATION

AWS SPECIFICATIONS	EN SPECIFICATIONS
AWS A 5.5: E7018-A1	EN ISO 2560-A: E 46 2 Mo B 42
	EN ISO 3580-A: E Mo B 4 2 H5

ALLOY TYPE

Low-alloy basic-coated electrode with 0.5% Mo content for welding low-alloy steels with high tensile strength.

APPLICATIONS

Low-alloy basic-coated electrode with 0.5% Mo content designed for welding low-alloy steels with high tensile strength and creep-resistant steels. Suitable for pipelines and pressure vessels with operating temperatures of about 500°C. Good impact strength at low temperatures.

TYPICAL CHEMICAL COMPOSITION OF WELD METAL

C %	Mn %	Si %	S %	P %	Cu %	Ni %	Cr %	Mo %
0.04	0.70	0.40	0.025	0.025	-	-	-	0.50

TYPICAL MECHANICAL PROPERTIES

	Yield strength	Tensile strength	Elongation on % 5d	Impact energy (Charpy V)				
	Rs	Rm	A 5d	0°C	-20°C	-30°C	-40°C	-60°C
	(MPa)	(MPa)	%	(Joule)	(Joule)	(Joule)	(Joule)	(Joule)
as welded	480	570	26	-	80	-	-	-

WELDING GUIDELINES

Preheat and interpass temperature 100°C. PWHT at 620°C for an hour. To be reconditioned at 370÷400°C for an hour (max 3 times) if necessary.

TECHNICAL INFORMATION

Welding positions: all positions except vertical down



WELDING PARAMETERS

Current	AC /DC + Reverse polarity		
Diameter (mm)		3.2	
Length (mm) *		350	
Current (A)		90 ÷ 140	

Diam.	Pack/Carton	Part No.
3.2mm	2kg VAC pack/12kg	INEA132

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