

# SW 702Mo

Submerged Arc Welding Wire - Unalloyed & Low Alloyed Steels

Standards	
AWS/ASME SFA - 5.23	EA2
EN ISO 14171-A	S2Mo
TS EN ISO 14171-A	S2Mo

Approvals & Certificates		
CE	TUV	TSE

**Properties and Applications**

Mo-alloyed and solid, submerged arc welding wire suitable for welding general structural steels, low alloyed steels with medium and high tensile strengths, used in pressure vessel, boiler, tanks, pipe and heavy steel constructions. Copper coating increases electrical conductivity and resistance against rusting.

Typical Chemical Features of the Welding Wire				
Type of Analysis	C	Si	Mn	Mo
Welding Wire	0.10	0.15	1.10	0,50

Typical Chemical Values of Weld Metal					
Welding Flux	Type of Analysis	C	Si	Mn	Mo
SF 204	Weld Deposit	0.06	0.45	1.30	0.40
SF 212	Weld Deposit	0.05	0.75	1.40	0.45
SF 414	Weld Deposit	0.08	0.25	1.30	0.40
SF 113	Weld Deposit	0.04	0,50	1.65	0.45
SF 134	Weld Deposit	0.05	0.45	1.50	0.40
SF 401	Weld Deposit	0.07	0.20	1.40	0.40
SF 104	Weld Deposit	0.05	0.40	1.10	0,50
SF 304	Weld Deposit	0.05	0.35	1.40	0.45
SF 124	Weld Deposit	0.07	0.25	1.25	0.40

Typical Mechanical Values of Weld Metal						
Test Condition	Welding Flux	Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation A5 (%)	Charpy V-Notch Properties (J)	
As welded	SF 104	480	560	26	0°C → 65	-20°C → 50
As welded	SF 304	510	570	27	-20°C → 100	-30°C → 60
As welded	SF 124	520	590	26	0°C → 70	-20°C → 55
As welded	SF 204	520	610	28	-20°C → 90	-30°C → 60
As welded	SF 212	590	670	26	20°C → 50	0°C → 35
As welded	SF 414	510	590	28	-20°C → 130	-30°C → 80
As welded	SF 113	515	590	28	0°C → 60	-20°C → 50
As welded	SF 134	520	640	26	-20°C → 70	-30°C → 55
As welded	SF 401	500	570	28	-30°C → 90	-40°C → 70

**Application Information**

Welding Positions: PA PB PC

Polarity: = +

Welding Parameters & Efficiency

Diameter (mm)
1.60
2.00

2.40
3.20
4.00

#### Packaging Information

Product Code	Diameter (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
42000GJAM2	1.60	15 kg	15.80	1	15.00	Wire Basket Spool (K300MS)
42000HXAM2	2.00	25 kg	25.90	1	25.90	Wire Basket Spool (K435)
42000I2GM2	2.40	400 kg	415.60	1	415.60	Fiber Drum
42000I3GM2	2.40	600 kg	616.50	1	616.50	Fiber Drum
42000IXAM2	2.40	25 kg	25.90	1	25.90	Wire Basket Spool (K435)
42000L2GM2	3.20	400 kg	415.60	1	415.60	Fiber Drum
42000L3GM2	3.20	600 kg	616.50	1	616.50	Fiber Drum
42000L9GM2		1000 kg	0.00	1	0.00	COIL
42000LXAM2	3.20	25 kg	25.90	1	25.90	Wire Basket Spool (K435)
42000M2GM2	4.00	400 kg	415.60	1	415.60	Fiber Drum
42000M3GM2	4.00	550 kg	616.50	1	616.50	Fiber Drum
42000M9GM2	4.00	1000 kg	0.00	1	0.00	COIL
42000MXAM2	4.00	25 kg	25.90	1	25.90	Wire Basket Spool (K435)

#### Storage & Re-Drying Information

Shouldn't be exposed to high statical load and impact.  
It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.