TECHNICAL DATA SHEET

parweld
WELDING THE FUTURE

XP 2Mo — CREEP RESISTANT

CLASSIFICATIONS

EN ISO 14341-A	AWS A5.28
G 50 4 M21 2Mo	ER70S-A1

KEY FEATURES AND APPLICATIONS

- 0.5% Mo alloyed wire intended for welding similar composition steels.
- 2Mo is typically used for high-strength, creep-resistant low-alloy steel welding applications.
- The presence of molybdenum helps resist hydrogen attack in chemical process applications.
- Ideal for service temperature up to 500°C max.
- Commonly used in the construction of steam boilers, pressure tanks, gas pipes, shipbuilding sector, petrochemical industry, heat exchangers, building of cranes, bridges.

BASE MATERIALS

P295GH, P355GH, 16Mo3, 17Mo3, 14Mo6, S275, S355, S420, A210, A285, A335, A516, S275Ml, S355M, S420M, S460 15Mo3, 10MnMo45, 11MnMo45, GS60, GS22Mo4, 20MnMoNi5-5, 15NiCuMoNd5S, 17MnMoV64

CHEMICAL COMPOSITION OF WIRE %

	C	Si	Mn	P	S	Ni	Cr	Mo	V	Cu	Al	Ti + Zr
MIN	0.08	0.30	0.90	-	-	-	-	0.40	-	-	-	-
MAX	0.12	0.70	1.30	0.020	0.020	0.15	0.15	0.60	0.03	0.35	0.02	0.15

Single values are maximum values according to EN ISO 14341

MECHANICAL PROPERTIES OF ALL-WELD METAL - TYPICAL (MIN.) VALUES

Yield Strength (MPa)	Tensile Strength (MPa)	Elongation (%)	Impact ISO-V (J)	Test Temperature
520 (≥500)	610 (560 - 720)	25 (≥18)	70 (≥47)	-40°C

Test data for mechanical properties are not guaranteed since actual as welded conditions depend on numerous variables

OPERATING DATA

Shielding Gases	Polarity
EN ISO 14175 - M21	DC+

PACKAGING AND AVAILABLE SIZES

Part Number	Diameter (mm)	Spool	Weight (kg)	Pallet Qty
XP15200	0.8	BS300	15	72
XP15201	1.0	BS300	15	72
XP15202	1.2	BS300	15	72

MADE IN EU