

NOVOFIL SGMO

MIG/MAG welding wire for high strength steels

MIG/MAG

ER70S-A1 · G MoSi

DESCRIPTION

Solid wire for welding 0.5% Mo low-alloyed steels resistant to hot creep and fine-grained steels with a high elastic limit, under Ar/CO₂ gas mixture shielding. Suitable for the construction of pressure vessels and pipes subjected to operating temperatures up to 500 °C. Good resilience values at low temperatures.

CLASSIFICATION

SFA-5.28/5.28M:2005 AWS ER70S-A1

UNI EN ISO 21952-A:2012 - G MoSi

COATING TYPE

Copper coated

Bronze coated

Copper free

APPROVALS

CE

SHIELDING GASES

M21: Ar + 15-25% CO₂

C1: 100% CO₂

DIAMETERS

0.80

mm · .030 in

0.90

mm · .035 in

1.00

mm · .039 in

1.20

mm · .045 in

1.60

mm · .062 in

PACKAGING

ø mm	0.60	0.80	0.90	1.00	1.20	1.60
Spool	–	✓	✓	✓	✓	✓
Drum	–	✓	✓	✓	✓	✓

Spool weight: **15 kg – 16 kg – 18 kg**

Drum weight: **250 kg – 300 kg – 450 kg**

WELDING POSITIONS



PA

flat



PB

horizontal-vertical



PC

horizontal



PE

overhead



PF

vertical up



PG

vertical down

CHEMICAL ANALYSIS OF THE WIRE [%]

	C	Mn	Si	Ni	Mo	Cu
Value	0.1	1	0.55	0.1	0.5	0.15

MECHANICAL PROPERTIES OF THE WELD METAL

	Gas M21
Yield strength Re	≥ 400 MPa
Tensile strength Rm	≥ 615 MPa
Elongation A5	26%
Impact test KV (–20 °C)	90 J
Impact test KV (+20 °C)	150 J