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Comercial Designation: **ESSEN Mo IG**

Pattern: **AWS ER 80S D2**

Alloy Elements Included:	C	Si	Mn	Mo	Cr

Application Field:	Wire or small rod specially coppered to be used in the TIG process in junctions of high responsability and welding resistant steel with working temperatures up to 500ºC. Coppered for construction and boilers and vapour assembly of pressure recipients, pipelines root, resistant to growing old. Indicated for steel welding with 0,50% of Mo.
Technical Characteristics:	The deposited metal is indicated for unions, with X ray high quality. Its deposit answers to thermic treatment, resistant and oxidation and to growing old.
Mechanical Proprieties:	Traction resistance: 60-70 Kp/ mm² Elasticity Limit: 47-49 Kp/mm² Extension L = 5 d.%: 22 % Resilience kpm/cm2: DVM 17-22
Operational Characteristics:	For process TIG Small rods of 1.000mm
	Welding Position: ----------

∅ in mm	0,80 MIG 1,60 Small Rod	1,00 MIG 2,40 Small Rod	1,20MIG 3,20 Small Rod	1,60MIG
Package:	Bobbin 15-18 kg Small Rod 10 kg	Bobbin 15-18 kg Small Rod 10 kg	Bobbin 15-18 kg Small Rod 10 kg	Bobbin 15-18kg Small Rod 10 kg

Welding Techniques:	Remove the ink, grease, rudiness of the area to be welded. Regulate the necessary flowing out gas, avoid oscilant movements (zig-zag) during the welding process so it will not fail to protect the arch when it touches the corners. Keep the torch in a correct distance in accordance to the chamfer. Regulate the fount according to the thickness of the part and O the small rod. To stablish the opening of the arch use a small copper plate, use CHEM-SHARP automatically to apoint the tungstenium electrode.