

MT-Mo / MT-5424

1.5424

Low-alloy molybdenum-containing steel MIG/TIG wire for welding heat resisting steels, suitable for working temperatures of up to +500°C.

Standard designation

Material No.	1.5424
AWS/ASME SFA-5.28	ER 80 S-G
EN ISO 14341-A	G42 4 C/M G 2Mo
EN ISO 21952-A	G/W Mo Si
EN ISO 636-A	W 46 4 W2Mo

Main base metals

P235G1TH-P255G1TH, P235GH-P310GH, 16Mo3, L320, L360NB-L415NB

Mechanical properties of all – weld – metal (typical values)

Welding process Gas shield Test temperature	[°C]	TIG I1		MIG M21	
		+20°C	-40°C	+20°C	-40°C
0,2%-yield strength R _{p0,2}	MPa	>460		>420	
Tensile strength R _m	MPa	530-680		500-600	
Elongation A ₅	[%]	>20		>20	
Impact strength A _v	[J]		>47		>47

Average chemical composition of all-weld-metal (%)

C	Si	Mn	Mo
0,08-0,12	0,3-0,7	0,9-1,3	0,4-0,6

Gas types applicable TIG Gas types applicable MIG

I1
M 21

Approvals TIG (MT-5424) Approvals MIG

TÜV, DB, CE
TÜV, DB, CE

TIG rod diameters available, unit weights

Diameter [mm]	Length [mm]	kgs per box
1,60	1000	25,0
2,00	1000	25,0
2,40	1000	25,0
3,20	1000	25,0

MIG welding wire

Diameter 0,8 mm 1,0 mm 1,2 mm 1,6 mm

Welding positions MIG acc.to EN ISO 6947 Welding positions TIG acc.to EN ISO 6947

PA, PB, PC, PF, PG
PA, PB, PC, PE, PF

Current/Polarity TIG

= -

Current/Polarity MIG

= +