VENVU AMC 35

Classifications

EN ISO 17634-A	AWS A5.28
T MoL M M 2 H5	E80C-GMH4

Characteristics and typical fields of application

Seamless, Molybdenum alloyed, metalcored wire for single or multipass welding of similar steels resistant to creep up to 450°C with Ar-CO_2 shielding gas. Features include: high yield, good weldability, excellent bead appearance and no spatter or slag. Wire with very low amount of diffusible hydrogen (<3ml/100g) that reduces the risk of cracks.

Base materials

EN 10028-2: P235GH - P265GH - P295GH - P355GH - 16Mo3 - 18MnMo4-5 - 20MnMoNi4-5
EN 10028-3: P275NH - P355NH - P460NH, **EN 10028-6:** P355QH - P460QH - P500QH
EN 10213-2: GS-17CrMo55 - GS-22CrMo5 - GS-22CrMoV32 - GS-CrMo54 - 15CrMo3 - 13CrMoV42

Typical analysis of all-weld metal (wt.-%)

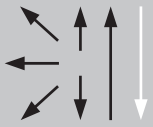
C	Mn	Si	P	S	Mo	Gas
0.06	**1.40**	**0.35**	**< 0.025**	**< 0.025**	**0.50**	**M21**

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

Condition	Yield strength $R_{p0.2}$	Tensile strength R_m	Elongation A (L_0=5d_0)	Impact work ISO-V KV J	
	MPa	MPa	%	-20°C	
u	**470**	**550**	**20**	**70**	

u: untreated, as welded – shielding gas Ar + 18% CO_2

Operating data



Ø (mm)	Current A	Voltage V
1.00	40 - 270	11 - 32
1.20	50 - 320	12 - 35
1.40	60 - 360	14 - 36
1.60	60 - 390	16 - 37
2.00	100 - 420	17 - 39
2.40	150 - 450	18 - 41

Approvals

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