

Classifications

AWS A5.23 / SFA-5.23
EN ISO 14171-A

EA3

S4Mo

Characteristics and typical fields of application

Union S 4 Mo is a coppered solid wire for submerged arc welding of creep resistant 0,5%Mo steel grades (16Mo3) ; also 2-run procedures in unalloyed steel grades (e.g pipe manufacturing).

Typical analysis

	C	Si	Mn	Mo
wt.-%	0.11	0.10	2.00	0.50

Operating data

Dimension mm

4.0

4.8

Recommended SAW flux:

UV 309 P	UV 420 TT	UV 421 TT
UV 310 P	UV 420 TT-LH	
UV 418 TT	UV 420 TTR	

Approvals

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