EN 12536:2000:	O IV
AWS A5.2-07:	R60-G
AWS A5.2M-07:	RM40-G
W. No.:	1.5425

BÖHLER DMO

gas welding rod,
low-alloyed, high temperature

Description

Mo-alloyed gas welding rod recommended for mild steels and 0.5% Mo alloyed steels. High viscous weld puddle. Easy to operate. Approved in long-term condition up to +500°C service temperature.

Typical Composition of All-weld Metal

	C	Si	Mn	Mo
wt-%	**0.12**	**0.15**	**1.0**	**0.5**

Mechanical Properties of All-weld Metal

		u	
yield strength R_e N/mm^2 (MPa):		**330**	(≥295)
tensile strength R_m N/mm^2 (MPa):		**470**	(≥440)
elongation A (L_0=5d_0) %:		**24**	(≥22)
impact work ISO-V KV J	+20°C:	**60**	(≥39)

u *untreated, as-welded*

Operating Data

rod marking:
front: **O IV**
back: **R60-G**

ø mm
2.0
2.5
3.2
4.0

Preheating and post weld heat treatment as required by the base metal.

Base Materials

high temperature steels, same alloyed

16Mo3, P285NH, P295NH, P255G1TH, P295GH

ASTM A335 Gr. P1, A36 Gr. all; A283 Gr. B, C, D; A285 Gr. B; A414 Gr. C; A442 Gr.60; A515 Gr. 60; A516 Gr. 55, 60; A570 Gr. 33, 36, 40

Approvals and Certificates

TÜV-D (0146.), DB (70.014.03), ÖBB, SEPROZ, CE

Same Alloy Filler Metals

SMAW electrode:	FOX DMO Kb	GMAW solid wire:	DMO-IG
	FOX DMO Ti	SAW combination:	EMS 2 Mo/BB 24
GTAW rod:	DMO-IG		EMS 2 Mo/BB 25
Flux cored wire:	DMO Ti-FD		

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