

ER 80S-D2

CATEGORY GMAW-GTAW Solid wires

TYPE Solid welding wire for Mag welding of steel grades upto 550 N/mm2 yield strength

APPLICATIONS Steel construction, shipbuilding, pressure vessels, mechanical engineering, pipe work, offshore, crane building, heavy transport, lifting equipment respecting the NACE requirements..

PROPERTIES Excelent for use in automated welding applications such as orbital Mag or robotic welding. This wire offers a unique covering range that enables you to use only one wire to cover more procedures upto 550 N/mm2 yield strenght steels. It can also be used for constructions that needs post weld heat treatment after welding and still offers excellent impact properties.

CLASSIFICATION

AWS	A 5.28: ER 80S-D2
EN ISO	14341-A: G 46 4 M G4Mo
DIN	8575:

SUITABLE FOR P235GH, P265GH, P295GH, P355GH, 16Mo3, 18MnMo4-5, 20MnMoNi4-5, P275NH, P355NH, P460NH, P355QH, P460QH, P500QH, GS-17CrMo55, GS-22CrMo5, GS-22CrMoV32, GS-CrMo54, 15CrMo3, 13CrMoV42, S550QL1, OPTIM 500ML, PAS 65 us, PAS 70 us, Dilimax 500, Dilimax 550, AISI 4130, 4140, 8630 and ASTM grades A182 Grade F22

APPROVALS CE approved

WELDING POSITIONS:



ALL-WELD METAL ANALYSES % (TYPICAL)

C	Mn	Si	Cu	Mo	P	S
0.08	1.8	0.7	0.12	0.5	0.010	0.010

MECHANICAL PROPERTIES (M21)

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
				-20°C	-40°C	-60°C	
AW	560	650	22	90	>47		

AW: as welded

WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters		spool type	Packing	
	Voltage (V)	Current (A)		kg / spool	kg / pallet
0.8	18-24	60-200	D-200 / K-300	5 / 15	1000 / 1080
1.0	18-32	80-300	D-200 / K-300	5 / 15	1000 / 1080
1.2	18-35	120-380	K-300	15	1080

REDRYING TEMPERATURE not required

TIG WELDING 1000 mm. cut lenghts are available from 1,6 till 3.2 mm in 5 kg tubes.