


CATEGORY	GTAW Solid wires																					
TYPE	Solid welding wire for Tig welding of steel grades up to 550 MPa yield strength																					
APPLICATIONS	Steel construction, shipbuilding, pressure vessels, mechanical engineering, pipe work, offshore, crane building, heavy transport, lifting equipment respecting the NACE requirements.																					
PROPERTIES	CEWELD ER80S-D2 Tig is a copper coated welding wire for welding of high strength steels, used predominantly after stress relieving. May find its use for joining creep resistance steels up to about 500°C but the CEWELD SG MO wire would be the more usual choice																					
CLASSIFICATION	AWS	A 5.28: ER 80S-D2																				
	EN ISO	21952-A: W Z4Mo																				
	EN ISO	636-B: W 57A 4 M31																				
	F-nr	6																				
	FM	1																				
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																					
WELDING POSITIONS:																						
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>Mo</th> </tr> </thead> <tbody> <tr> <td>0.08</td> <td>0.7</td> <td>1.8</td> <td>0.5</td> </tr> </tbody> </table>			C	Si	Mn	Mo	0.08	0.7	1.8	0.5											
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ALL WELD MECHANICAL PROPERTIES	<table border="1"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R_{p0,2} MPa</th> <th rowspan="2">R_m MPa</th> <th rowspan="2">A₅ (%)</th> <th rowspan="2">RT</th> <th colspan="2">Impact Energy (J) ISO-V</th> </tr> <tr> <th>-40°C</th> <th>-50°C</th> </tr> </thead> <tbody> <tr> <td>As Welded /1h</td> <td>540</td> <td>620</td> <td>24</td> <td>150</td> <td>55</td> <td>47</td> </tr> </tbody> </table>						Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	RT	Impact Energy (J) ISO-V		-40°C	-50°C	As Welded /1h	540	620	24	150	55	47
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WELDING PARAMETERS / PACKING																						
REDRYING TEMPERATURE	Not required																					
GAS ACCORDING EN 14175	I1																					