


ER 80S-D2

CATEGORY	GMAW-GTAW Solid wires
TYPE	Solid welding wire for Mag welding of steel grades upto 550 N/mm ² 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/mm ² 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
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APPROVALS	CE approved
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WELDING POSITIONS:	
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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					
Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	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
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TIG WELDING	1000 mm. cut lenghts are available from 1,6 till 3.2 mm in 5 kg tubes.
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