

ER80S-D2

AWS A5.28 ER80S-D2

Description:

ER80S-D2 is a low alloy copper-coated tig rod with 0.5% Mo content designed for welding low-alloy steels with high tensile strength and creep resistance. It shows good impact strength at low temperatures and suitable for pipelines and pressure vessels with operating temperatures of about 500 ° C. It will also find applications for the repair of medium strength steel castings

Welding Position:



Diameters:

1.2mm

Typical Mechanical Properties:

Tensile strength(MPa):	720
Yield strength(MPa):	610
Elongation(%):	27
Impact values(≥ 27)/-20°C):	76

Typical Chemical Composition:

C	Mn	P	S	Si	Mo	Cu
0.08	1.90	0.010	0.008	0.70	0.50	0.15

Welding Current:

Diameter(mm)		0,8	1,0	1,2	1,6
Current/A	F/H	50-200	80-250	100-360	170-390
Current/A	V/OH	50-140	80-160	80-220	--

Note:

1. Rusty, water, oil and other impurity should be cleaned before welding.
2. Shield gas: 80%Ar+20% CO₂.
3. Gas speed: 15-25L/Min
4. Tig rods ER80S-D2 1.6mm, 2.0mm, 2.4mm, 3.2mm available