

ER80S-D2

LOW ALLOY HIGH TENSILE SOLID WIRES



SIZE

0.9mm

1.2mm

1.6mm

AMPS

75-200A

90-350A

170-390A

CHARACTERISTICS

- 1, Superior arc stability
- 2, Low spatter level and a flat bead with excellent appearance
- 3, High ductility, excellent impact values and tensile strengths of the bead

TYPICAL APPLICATIONS

- 1, Farm implements
- 2, Automotive parts, pipes, light-gauge steels
- 3, Low alloy steels such as AISI 4130 and high yield steels such as T-1.

CLASSIFICATION

AWS A5.28 ER80S-D2

WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PF/3Gu



PE/4G

EQUIVALENT TO

CHEMICAL COMPOSITIONS (Wt%), ALL WELD METAL, TYPICAL

C	Si	Cu	Mn	Mo	P	S
0.08	0.70	0.15	1.90	0.5	0.01	0.009

AVAILABLE SIZES (DIA.)

0.9mm/1.2mm/1.6mm

PACKAGING DETAILS

1/5/15kg Spools 250/350kg Drums

CURRENT TYPE

DC+

MECHANICAL PROPERTIES, ALL WELD METAL, TYPICAL

Condition	Shielding Gas	Yield Strength (mpa)	Tensile Strength (mpa)	Elongation(%)	Charpy V notch(J)
AW	100% Ar	570	660	22	-20 C 88

