

❖ Product Description

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| I. Copper coated solid wire | V. It gives good wetting, rust and scale tolerance |
| II. Uniform copper coating | VI. Weld toughness increases at sub-zero temperature |
| III. Mn-0.5Mo type weld deposits | VII. Radiographic weld quality |
| IV. Strength is increased due presence of Mo | |

❖ Range of Application

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| I. For welding Mn and 0.5Mo steels | III. Suitable for a single and multipass welding |
| II. For pipelines and pressure vessels where resistance to sulphide-induced stress corrosion cracking is essential | IV. Highly suitable for welding variety of low alloy, higher strength steels |

❖ Classification

- AWS/SFA 5.28 ER80S- D2

❖ % Chemical Composition

Type of Wire		C	Mn	S	Si	Ni	Mo	P	Cu	Other Elements
ER80S- D2	Min	0.07	1.60	-	0.50	-	0.40	-	-	-
	Max	0.12	2.10	0.025	0.80	0.15	0.60	0.025	0.50	0.50

❖ Mechanical Properties of all weld metal

Condition	UTS, Mpa (Min)	YS, MPa (Min)	% Elongation	Charphy "v" Notch Impact @ -30°C
As Welded	550	470	17	30J

❖ Wire Size & Welding Position

- Diameter in mm- 0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60
- Weld Position- All position

❖ Current & Gas Flow

- DCEP; 15-22lit/min

❖ Packaging

Sizes Available in mm	0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60								
Packing Code	A	B	C	D	E	F	G	H	I
Packing Available	SD 100	SD200	SD270	SD 270	SD300	SD300	100kg Drum Pack	250kg Drum Pack	350kg Drum Pack
Net Weight of Wire	1KG	2KG	12.5KG	15KG	12.5KG	15KG	100KG	250KG	350KG

Special Notes: -

- (1) All the value above mentioned are typical values.
- (2) Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding.

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