

❖ Product Description

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| I. Low alloy steel Mg-Mo copper coated wire | IV. Excellent toughness characteristics at sub-zero temperatures |
| II. The weld deposit has excellent tensile strength as much as 560MPa | V. Uniform copper coating |
| III. Contains 0.5%Mo for good strength and stress values | VI. Porosity free radiographic welding |

❖ Range of Application:

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| I. Excellent in high temperature pipe fittings, flanges, valves which carry oil in them | III. Suitable for welding ordinary and difficult to weld carbon and low alloy, higher strength steels in both as welded and PWHT conditions. |
| II. Suitable for single and multipass welding | |

❖ Classification

- AWS/SFA 5.28 ER80S-D2

❖ % Chemical Composition

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

❖ Mechanical Properties of all weld metal

Condition	UTS, Mpa (Min)	YS, Mpa (Min)	% Elongation	Charpy "v" Notch Impact @ -30°C
As Welded	550	470	17	27J

❖ Wire Size & Weld Position

- Diameter in mm-1.6, 2.0 2.40,3.20,4.00 and 5.00.
- All position

❖ Current and Gas- Flow Rate

- DCEN & 8-15 lit/min

❖ Packaging

Sizes available in cut length of 1000mm	1.60,2.00,2.40,3.20,4.00,5.00			
Packing Code	A		B	
Packing Available	5kg PLASTIC TUBE	20KG BOX	10KG PAPER TUBE	20KG BOX
Net Weight of Wire	5	20	10	20

Special Note: -

All the value above mentioned are typical values.

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- Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding.

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