

❖ Product Description

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| I. Low alloy steel manganese molybdenum copper coated wire | III. Gives good wetting, rust and scale tolerance |
| II. The weld deposit has excellent tensile strength as much as 560MPa | IV. Weld deposits resistant to cold cracking |
| | V. Radiographic weld quality |

❖ Range of Application:

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|---|---|
| I. Feasible for welding over wide range of base metals such as problem steels containing high sulphur to basic carbon and low alloy Cr-Mo base metals | II. Good for repairing of medium range of castings made up of steels |
| | III. For pipelines and pressure vessels which operate at nearly 500°C |

❖ Classification:

- AWS/SFA 5.28 ER80S-G

❖ % Chemical Composition

Type of Wire		C	Mn	Si	S	P	Cu	Ni	Mo	Other Elements Total
ER80S-G	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	Charphy "v" Notch Impact @ 0°C
As Welded	550	470	17	27J

❖ Sizes

- 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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