



AUTOMIG 80S-D2

GMAW LOW ALLOY STEEL (High Strength)

AWS A/SFA 5.28 **ER80S-D2**

CLASSIFICATION:

EN ISO 16834-B
G 4M31

KEY FEATURES:

- Copper coated solid filler wire and rod
- Mn-0.5 Mo type welds deposit
- Uniform copper coating
- Mo Provide increased strength
- High levels of Mn and Si provide good wetting, rust and scale tolerance
- Excellent sub-zero toughness
- Porosity free radiographic quality weld

APPROVALS: CE

TYPICAL APPLICATIONS:

- Welding of Mn-0.5 Mo steel
- Application in oil process pipe work and fittings where resistance to sulphide-induced stress corrosion cracking is important
- Suitable for single and multiple pass welding
- Variety of ordinary and difficult to weld carbon and low alloy, higher strength steels in both as welded and PWHT condition



TYPICAL CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt %:

C	Mn	Si	Mo
0.09	1.7	0.5	0.45

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -30°C, J
Typical	As Welded	590	500	21	55

PARAMETERS - PACKING DATA:

Ø, mm	Kg/Spool		
1.2	15	 DCEP STORAGE / HANDLING : Keep dry and follow handling instructions mentioned on the box	All Positions 
1.6	15		

Shielding Gas	Gas Flow Rate, LPM
CO ₂	15-22