

HI TENSILE MIG WIRE 80S-D2 HI TENSILE

FEATURES

- Solid copper coated Manganese (Mn) Molybdenum (Mo) gas metal arc welding wire.
- Designed for use on medium to higher strength steels with weld deposits of 550 MPa tensile strength
- All positional

APPROVALS & CLASSIFICATION

- AWS A5.28 ER80S-D2
- AS/NZS 14341-B-G 55A 3U M G431

APPLICATIONS

- Suitable for out of positional welding and ideal for welding Carbon Manganese steels and higher strength steels used in pressure vessels, boilers and pipelines.
- Also an ideal choice for welding high strength steels such as Bisalloy 60, 70 and 80 grades.



TECHNICAL DATA

Typical All Weld Metal Mechanical Properties	
Gas Type	Argon + 20% CO ₂
Yield Strength	570 MPa
Tensile Strength	660 MPa
Elongation	24%
CVN Impact Value	125 J @ 0°C

Typical All Weld Metal Analysis		
Carbon	Manganese	Silicon
0.08%	1.83%	0.70%
Phosphorus	Molybdenum	
0.01%	0.50%	

Operating Data		
Wire Dia.	Current Range	Voltage
0.9mm	70 - 240	15 - 26
1.2mm	110 - 350	18 - 32

Recommended Shielding Gas
Argon + 18 - 25% CO ₂
Argon + 1 - 3% O ₂
Welding Grade CO ₂

ORDERING INFO

Part Number	Size	Packet
200015	0.9mm	15kg
200016	1.2mm	15kg