



CEWELD ER 80S-D2 Tig

TYPE Solid welding wire for Tig welding of steel grades up to 550 MPa yield strength

APPLICATIONS Steel construction, shipbuilding, pressure vessels, mechanical engineering, pipe work, offshore, crane building, heavy transport, lifting equipment respecting the NACE requirements.

PROPERTIES CEWELD ER80S-D2 Tig is a copper coated welding wire for welding of high strength steels, used predominantly after stress relieving. May find its use for joining creep resistance steels up to about 500°C but the CEWELD SG MO wire would be the more usual choice

CLASSIFICATION

| | |
|--------|-------------------|
| AWS | A 5.28: ER 80S-D2 |
| EN ISO | 21952-A: W Z4Mo |
| F-nr | 6 |
| FM | 1 |

SUITABLE FOR P235GH, P265GH, P295GH, P355GH, 16Mo3, 18MnMo4-5, 20MnMoNi4-5, P275NH, P355NH, P460NH, P355QH, P460QH, P500QH, GS-17CrMo55, GS-22CrMo5, GS-22CrMoV32, GS-CrMo54, 15CrMo3, 13CrMoV42, S550QL1, 15NiCuMoNb5-6-4
 AISI 4130, 4140, 8630 and ASTM grades A182 Grade F22
 OPTIM 500ML, PAS 65 us, PAS 70 us, Dilimax 500, Dilimax 550,

APPROVALS CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

| C | Si | Mn | Mo |
|------|-----|-----|-----|
| 0.08 | 0.7 | 1.8 | 0.5 |

MECHANICAL PROPERTIES

| Heat Treatment | R _{P0.2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | | | Hardness |
|----------------|-------------------------|----------------------|--------------------|-------------------------|-------|-------|----------|
| | | | | RT | -40°C | -50°C | |
| As Welded | 540 | 620 | 24 | 150 | 55 | 47 | HRc |

REDRYING Not required

GAS ACC. EN ISO 14175 I1



CEWELD ER 80S-D2 Tig

ER 80S-D2 TIG 1,6 X
1000MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| Tube | 5 | 8720663416681 |

ER 80S-D2 TIG 2,4 X
1000MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| Tube | 5 | 8720663416698 |

ER 80S-D2 TIG 3,2 X
1000MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| Tube | 5 | 8720663416704 |