



F 80S-D2

CODIFICATION: AWS : SFA 5.28 ER80S-D2

CHARACTERISTICS AND APPLICATIONS:

F 80S-D2 is a copper-coated solid wire for GTAW, available in bright finish. The wire gives stable arc, smooth welding performances and deposits radiographic quality welds. It is recommended for welding of molybdenum (~0.5%) containing high strength fine-grained structural steels. The wire also is suitable for welding of penstock pipe-line, fabrication of earth moving equipments, etc. where high tensile strength property is desired from the weld metal. Suitable for welding of ASTM steels: SA-455/ SA-455M, Gr.60, Gr.65 steels of SA-515/ SA-515M, Gr.60, Gr.65 steels of SA-516/SA-516M, Class 1 of A, B, C, D grades of SA-533/ SA-533M, etc.

TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

Element	C	Mn	Si	S	P	Mo	Cu
%	0.075	1.78	0.55	0.014	0.015	0.45	0.15

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	YS (MPa)	Elongation (L=4d) %	CVN Impact Strength at minus 30°C (Joules)
680	560	22	55

SHIELDING GAS: Argon

CURRENT CONDITION: DCEN

WELDING POSITION: H, F, VU, OH

PACKING:

STANDARD SIZE Diameter 1.6 mm, 2.0 mm, 2.4 mm & 3.2 mm in cut lengths of 500 mm / 1000 mm each.

QUANTITY 5 kg wire put in an air-tight polythene bag and finally packed in a plastic container.
Identification AWS code is punched on each wire.