

GETIG 80SD2

IDENTIFICATION

Getig 80S-D2, ER 80SD2

CLASSIFICATION

AWS/SFA 5.28: ER 80S-D2

DESCRIPTION

Copper coated solid wires alloyed with manganese & molybdenum for improved properties. Deposited weld metal has excellent creep resistance properties up to 500° C.

CHEMICAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Ni	Mo	Cu
0.07 - 0.12	1.60 - 2.10	0.5 - 0.80	0.025 max	0.025 max	0.15 max	0.40 - 0.60	0.35 max

MECHANICAL PROPERTIES (RANGE)(PWHT 620 ±15OC/2 HRS.)

UTS (MPa)	YS (MPa)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
550 min	470 min	17 - 25	-30°C	45

TYPICAL APPLICATIONS

- In general usable on the following grades of creep resistant steels.
- DIN 15 Mo3, GS-22Mo4, 19Mn6, 17Mn4 ASTM A3 36 Gr F1, ASTM A 335Gr P1, ASTM A185 Gr F1 etc.

SHIELDING GAS : 99.99 % Argon, 7-12 l/min, and back purge.

WELDING CURRENT : DC (-)

PREHEAT AND INTERPASS TEMPERATURE: 135 - 165°C

PACKING PARAMETERS

Size (mm)	Length (mm)	Packing / Pkt (kg)	Packing / Box (kg)
1.6	1000	5	5 x 4 = 20
2	1000	5	5 x 4 = 20
2.40 / 2.50	1000	5	5 x 4 = 20
3.15 / 3.20	1000	5	5 x 4 = 20