GWELD
SEAL OF TRUST

GM 80SG

IDENTIFICATION
GM 80SG, ER 80SG

CLASSIFICATION
AWS/SFA 5.28 ER 80SG

DESCRIPTION
Copper coated solid wires alloyed 1.5% Mn, 0.40 % Mo intended for welding of similar composition used in power generating plant operating at welding of high tensile steels.

CHEMICAL ANALYSIS (RANGE) %

C	Mn	Si	Mo	P	S	Cu
0.07 - 0.12	1.5 - 20.0	0.40 - 0.60	0.40 - 0.60	0.025 max	0.025 max	0.35 max

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	YS (MPa)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
550 min	470 min	17 min	-30°C	27 min

TYPICAL APPLICATIONS

- For welding low alloy steel AISI 4130, 4140 for the repair and fabrication of manganese molybdenum castings.
- AISI 4130, castings to ASTM A 487 2 A-B-C Fabrication of higher strength steels for off-shore oil well head process pipe work and fittings.
- Repair of medium strength low alloy steel castings. fabrication of steel to IS 8500-91 Gr 540B, 570B, 590B, IS2002-92Cr3

PREHEAT AND INTERPASS TEMPERATURE : 135 - 165ºC

SHIELDING GAS : 80% Ar + 20% CO2

WELDING CURRENT : DC (-)

PACKING PARAMETERS

Size (mm)	Weight / Spool (kg)
1.2	12.50 / 15.0
1.6	12.50 / 15.0