

STRONG 80S-D2

CLASSIFICATION: AWS SFA 5.28 ER 80S-D2

Copper Coated Solid Wire For MIG & TIG Welding



CHARACTERISTICS

STRONG 80S-D2 is a low alloy steel wire designed for welding low alloy fine grained structural steels with 0.5% Mo content. This wire contains a high level of deoxidizers (manganese & silicon) to control porosity when welding with CO₂ as the shielding gas, and molybdenum for increased strength and corrosion property.

APPLICATIONS

STRONG 80S-D2 is suitable for welding of penstock pipe-line, fabrication of earth moving equipment, structural steels etc. where high tensile strength property is desired from the weld metal with operating temperatures of about 500°C.

TYPICAL WIRE CHEMISTRY (%)

C	Mn	Si	P	S	Cu	Ni	Cr	Mo	V
0.07-0.12	1.60-2.10	0.50-0.80	0.025 MAX	0.025 MAX	0.50 MAX	0.15 MAX	0.15 MAX	0.40-0.60	0.03 MAX

ALL WELD MECHANICAL PROPERTIES

Required as per AWS 5.28	Y.S.	U.T.S.	ELONGATION	IMPACT VALUE AT -30°C
	MPa	MPa	%	JOULE
	≥470	≥550	≥17	≥27
Typical	535	640	22	55

PACKAGING SPECIFICATIONS - MIG

DIA SIZE 0.80MM / 1.00MM / 1.20MM / 1.60MM / 2.00MM

SPOOL WEIGHT 1KGS / 5KGS / 12.5KGS / 15KGS / 17.5KGS

DRUM WEIGHT 100KGS / 150KGS / 250KGS / 300KGS / 350KGS

PACKAGING SPECIFICATIONS - TIG

DIA SIZE 1.60MM / 2.00MM / 2.40MM / 3.15MM / 4.00MM

WEIGHT 5KGS / 20KGS