

CLASSIFICATION

AWS A5.28: ER80S-D2 EN ISO 636-B : W4Mo
TS EN ISO 21952-A : W MnMo
EN ISO 21952-A: W MnMo

GENERAL DESCRIPTION

It is a low alloyed TIG rod, used for the welding low alloyed and high strength steels in operating temperatures up to 550°C. It is used in the welding of creep resistant steels, boiler and pressure vessels, gas pipes. Especially used for low temperature applications that are manufactured from Ni-Cr-Mo steels.

Industry: Transportation, bridge, tank and railway fabrication, mining, ship building and petro-chemical industry

CHEMICAL COMPOSITION (W%) TYPICAL, WIRE

C	Si	Mn	Ni	Cr	Mo	Cu
0.09	0.70	1.90	<0.15	0.15	< 0.50	< 0.25

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Yield Strength : 570 N/mm²
Tensile Strength : 690 N/mm²
Elongation (L=5d) : 25 %
Impact (ISO-V) : 120 J (+20°C)
80 J (-20°C)

SHIELDING GASES (ISO 14175 / EN 439)

TIG : I1 - Ar (100%)

Current Type and Polarity : DC (-)

MATERIALS TO BE WELDED

	DIN	EN
General Structural Steels	St 52.3	S355
Fine Grained Steels	StE 255 - StE 460 ; WStE 255 - WStE 460	S255N - S460N ; P255NH - P460NH
Pipe Materials	StE 320.7 - StE 415.7 StE 360.7 TM - StE 480.7 TM X52, X56, X60, X65 (API 5LX)	L320 - L415NB L360MB - L485MB -
Boiler and Pressure Vessel Steels	15Mo3, 17Mn4, 19Mn6 22Mo4, 20MnMoNi55 -	16Mo3, P295GH, P310GH - P355GH
Elevated Temperature Steels	St 35-8, St 45-8	P235G1TH - P255G1TH
Cast Steels	GS-45, GS-52, GS-60 -	GE240, GE260, GE300 G20Mo5
Creep Resistant Steels	17MnMoV6-4, 15NiCuMoNb5 -	- 20MnMoNi4-5

PACKING AND DIAMETER INFORMATIONS

Diameter	0.8	1.0	1.2	1.6	2.0	2.4	3.2	Tube Weight
TIG ROD	-	-	-	X	X	X	-	5 kg

Liability : All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance.
Fumes : Consult information on Welding Safety Sheet, available upon request.