



# CEWELD ER 80S-D2 Tig

**TYPE** Solid welding wire for Tig welding of steel grades up to 550 MPa yield strength

**APPLICATIONS** Steel construction, shipbuilding, pressure vessels, mechanical engineering, pipe work, offshore, crane building, heavy transport, lifting equipment respecting the NACE requirements.

**PROPERTIES** CEWELD ER80S-D2 Tig is a copper coated welding wire for welding of high strength steels, used predominantly after stress relieving. May find its use for joining creep resistance steels up to about 500°C but the CEWELD SG MO wire would be the more usual choice

**CLASSIFICATION**

AWS	A 5.28: ER 80S-D2
EN ISO	21952-A: W Z4Mo
F-nr	6
FM	1

**SUITABLE FOR** P235GH, P265GH, P295GH, P355GH, 16Mo3, 18MnMo4-5, 20MnMoNi4-5, P275NH, P355NH, P460NH, P355QH, P460QH, P500QH, GS-17CrMo55, GS-22CrMo5, GS-22CrMoV32, GS-CrMo54, 15CrMo3, 13CrMoV42, S550QL1, 15NiCuMoNb5-6-4  
 AISI 4130, 4140, 8630 and ASTM grades A182 Grade F22  
 OPTIM 500ML, PAS 65 us, PAS 70 us, Dilimax 500, Dilimax 550,

**APPROVALS** CE

**WELDING POSITIONS**

**TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)**

C	Si	Mn	Mo
0.08	0.7	1.8	0.5

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>P0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness
				RT	-40°C	-50°C	
As Welded	540	620	24	150	55	47	HRc

**REDRYING** Not required

**GAS ACC. EN ISO 14175** I1



# CEWELD ER 80S-D2 Tig

ER 80S-D2 TIG 1,6 X  
1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663416681

ER 80S-D2 TIG 2,4 X  
1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663416698

ER 80S-D2 TIG 3,2 X  
1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663416704