

CEWELD ER 80S-D2

TYPE Copper- coated solid wire for MAG welding of steel grades up to 550 MPa yield strength. (ER 80S-D2, G4Mo)

APPLICATIONS CEWELD® ER 80S-D2 is for welding high-strength steels up to 550 MPa yield strength. Mainly in the following areas: Steel construction, shipbuilding, pressure vessels, mechanical engineering, pipe work, offshore, crane building, heavy transport, lifting equipment respecting the NACE requirements

PROPERTIES CEWELD® ER 80S-D2 is excellent for use in automated welding applications such as orbital Mag or robotic welding. This wire offers a unique covering range that enables you to use only one wire to cover more procedures up to 550 MPa yield strength steels. It can also be used for constructions that needs post weld heat treatment after welding and still offers excellent impact properties.

CLASSIFICATION

| | |
|--------|-------------------------|
| AWS | A 5.28: ER 80S-D2 |
| EN ISO | 14341-A: G 50 5 M21 4Mo |
| F-nr | 6 |
| FM | 1 |

SUITABLE FOR **Reh ≤ 500 MPa ISO 15608: 1.2, 1.3, 2.1, 9.2**
 1.5637, 1.6217, 1.6228, 1.0044-1.09821.0035 - 1.0570, 1.0345, 1.0425, 1.0481, 1.0308 - 1.0581, 1.0307 - 1.0582, 1.0440, 1.0472, 1.0475, 1.0416 to 1.0551
 10Ni14, 12Ni14, 13MnNi6-3, 15NiMn6, S275N-S460N, S275NL-S460NL, S275M-S460M, S275ML-S460ML, P275NL1-P460NL1, P275NL2-P460NL2
ASTM A 203 Gr. D, E; A 333 Gr. 3; A334 Gr. 3; A 350 Gr. LF1, LF2, LF3; A 420 Gr. WPL3, WPL6; A 516 Gr. 60, 65; AA 529 Gr. 50; A 572 Gr. 42, 65; A 633 Gr. A, D, E; A 662 Gr. A, B, C; A 707 Gr. L1, L2, L3; A 738 Gr. A; A 841 A, B, C
NFA 35-207: A510PP1 – A550PP2
NFA 36208: 3.5 Ni 285 ct 355 (12N14)
 OPTIM 500ML, PAS 65 us, PAS 70 us, Dilimax 500, Dilimax 550, Weldom 500

APPROVALS CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

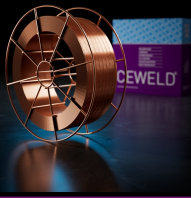
| C | Si | Mn | Mo | Cu |
|------|-----|-----|-----|-----|
| 0.08 | 0.7 | 1.8 | 0.5 | 0.1 |

MECHANICAL PROPERTIES

| Heat Treatment | R _{P0.2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | | | Hardness |
|----------------|-------------------------|----------------------|--------------------|-------------------------|-------|-------|----------|
| | | | | RT | -50°C | -70°C | |
| As Welded | 560 | 650 | 22 | 160 | 70 | 50 | HRc |

REDRYING Not required

GAS ACC. EN ISO 14175 M21



CEWELD ER 80S-D2

ER 80S-D2 0,8MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| BS-300 | 15 | 8720663416711 |
| D-200 | 5 | 8720663416674 |

ER 80S-D2 1,0MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| BS-300 | 15 | 8720663406316 |

ER 80S-D2 1,2MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| BS-300 | 15 | 8720663416735 |