



CEWELD ER 80S-D2 Tig

TYPE	Solid welding wire for Tig welding of steel grades up to 550 MPa yield strength							
TOEPASSINGEN	Steel construction, shipbuilding, pressure vessels, mechanical engineering, pipe work, offshore, crane building, heavy transport, lifting equipment respecting the NACE requirements.							
EIGENSCHAPPEN	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 M0 wire would be the more usual choice							
CLASSIFICATIE	AWS	A 5.28: ER 80S-D2						
	EN ISO	21952-A: W Z4Mo, 636-B: W 57A 4 M31						
	F-nr	6						
	FM	1						
GESCHIKT VOOR	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, Weldox 500							
GOEDKEURINGEN	CE							
LASPOSITIES	      							
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si		Mn		Mo		
	0.08	0.7		1.8		0.5		
MECHANISCHE WAARDEN	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Impact Energy (J) ISO-V			Hardness
					RT	-40°C	-50°C	
	As Welded	540	620	24	150	55	47	HRc
HERDROGEN	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