




CEWELD ER 80S-D2 Tig

TYPE	Solid welding wire for Tig welding of steel grades up to 550 MPa yield strength							
ANWENDUNGEN	Steel construction, shipbuilding, pressure vessels, mechanical engineering, pipe work, offshore, crane building, heavy transport, lifting equipment respecting the NACE requirements.							
EIGENSCHAFTEN	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							
KLASSIFIKATION	AWS	A 5.28: ER 80S-D2						
	EN ISO	21952-A: W Z4Mo						
	F-nr	6						
	FM	1						
GEEIGNET FÜR	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,							
ZULASSUNGEN	CE							
SCHWEISSPOSITIONEN								
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	Mo				
	0.08	0.7	1.8	0.5				
MECHANISCHE GÜTEWERTE	Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness
	As Welded	540	620	24	RT	-40°C	-50°C	HRc
					150	55	47	
RÜCKTROCKNUNG	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