



CEWELD ER 80S-D2

TYPE	Solid welding wire for Mag 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	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	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, 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	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 RT -50°C	Hardness
	As Welded	560	650	22	160 70	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