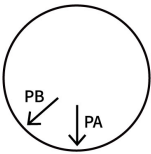


SM-80D2

Classification

AWS A5.28/ ASME SFA-5.28 ER80S-D2(100%CO2),
ER90S-D2(Ar-1~5%O2)

Welding Positions



Features

- Suitable for flat and horizontal fillet welding position.
- As the deposition rate is very high, highly efficient welding can be performed.
- As the wire contains special elements, its bead appearance is excellent.

Polarity

DC +

Application Areas

- Construction machinery, building and pressure vessels

Shielding Gas

100% CO2, Ar + 1~5% O2

Approvals

CE
✓

Typical Chemical Composition of the Wire (wt%)

C	Si	Mn	P	S	Mo
0.09	0.55	1.74	0.007	0.005	0.41

Typical Mechanical Properties of All-Weld Metal

Shielding Gas	Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft · lbs)
100% CO2	530 (77)	630 (91)	24	-30 (-20)	30 (22)
Ar + 5% O2	590 (86)	710 (103)	18	-30 (-20)	50 (37)

Diameter / Welding Parameters / Packaging

Wire Diameter mm(in)	Packaging
0.9 (0.035), 1.0 (0.039), 1.2 (0.045), 1.4 (0.052), 1.6 (1/16)	Spool 15kg(33lbs), 20kg (44lbs) Drum 250kg (551lbs), 300kg (661lbs), 350kg (771lbs)

SM-AW

GM-AW

GT-AW

FC-AW

Metal-cored Wire

SAW Wire

SAW Flux