

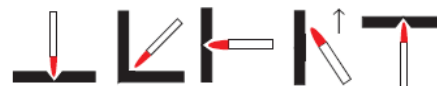
MAG/MIG Solid Wire: High Strength Steel



WW-80S-D2

Welding Position

Classification	AWS A5.28 ER80S-D2
	EN G 50 3 M G4Mo
	ISO 14343 A – G 50 3 M 21 G4Mo



Application and Properties:

WW-80S-D2 is copper coated MnMo type of MAG/MIG solid wire. It is suitable for using with CO₂ or Ar- CO₂ mixed shielding gas.

WW-80S-D2 is used in chemical plant construction operating at elevated temperatures up to 500°C. It is also suitable for welding of high yield strength steels up to 500 MPa.

Current	DC+
Shielding Gas	80%Ar + 20%CO ₂
Gas Flow	20-25 L/min
Elongation Length	15-25 mm

Notes: Rust Layer, moisture, oil stain, and dust of the welding part should be surely cleaned up. Under the circumstance of outdoor welding, if the wind speed is more than 1.5 cm/s, wind resistant actions should be taken; wind resistant facility is necessary to prevent porosity.

Typical Chemical Composition of All-Weld Metal:

Alloy wt%	C	Mn	Si	Mo	P	S	Cu
AWS	0.07-0.12	1.60-2.10	0.50-0.80	0.40-0.60	0.040	0.030	0.50
TYPE VALUE	0.082	1.84	0.74	0.44	0.013	0.012	0.20

Mechanical Properties of All-Weld Metal:

	Yield Stess (MPa)	Tensile Strength (MPa)	Elongation (%)	Charp V-notch J/°C
AWS	470	550	17	27/-30
Typical	480	608	25	53

Size Available and Recommended Parameter:

Dimension (mm)	Flat, Horizontal welding		Vertical Up		Overhead Welding	
	A	V	A	V	A	V
0.8	70-150	20-50	50-120	19-23	50-120	19-23
1.0	100-200	22-28	80-150	20-25	80-150	20-25
1.2	140-220	23-33	120-180	24-28	160-200	26-30