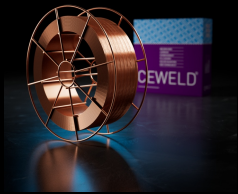


# CEWELD ER 80S-D2

|                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                         |                    |        |     |                            |
|---------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------|--------------------|--------|-----|----------------------------|
| TYPE                                              | Copper- coated solid wire for MAG welding of steel grades up to 550 MPa yield strength. (ER 80S-D2, G4Mo)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                         |                    |        |     |                            |
| APPLICATIONS                                      | CEWELD® ER 80S-D2 is for welding high-strength steels up to 550 MPa yield strength. Mainly in the following areas: Steel construction, shipbuilding, pressure vessels, mechanical engineering, pipe work, offshore, crane building, heavy transport, lifting equipment respecting the NACE requirements                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                         |                    |        |     |                            |
| PROPERTIES                                        | CEWELD® ER 80S-D2 is 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                                      | <b>Reh ≤ 500 MPa ISO 15608: 1.2, 1.3, 2.1, 9.2</b><br>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<br>10Ni14, 12Ni14, 13MnNi6-3, 15NiMn6, S275N-S460N, S275NL-S460NL, S275M-S460M, S275ML-S460ML, P275NL1-P460NL1, P275NL2-P460NL2<br><b>ASTM</b> 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<br><b>NFA 35-207:</b> A510PP1 – A550PP2<br><b>NFA 36208:</b> 3.5 Ni 285 ct 355 (12N14)<br>OPTIM 500ML, PAS 65 us, PAS 70 us, Dilimax 500, Dilimax 550, Weldox 500 |                         |                    |        |     |                            |
| 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 |                            |
| ALL WELD MECHANICAL PROPERTIES                    | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | R <sub>P0,2</sub> MPa   | R <sub>m</sub> MPa | A5 (%) | RT  | Impact Energy (J) ISO-V    |
|                                                   | As Welded /                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | 560                     | 650                | 22     | 160 | -50°C<br>70<br>-70°C<br>50 |
| REDRYING TEMPERATURE                              | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                         |                    |        |     |                            |
| GAS ACCORDING EN 14175                            | M21                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                         |                    |        |     |                            |



# CEWELD ER 80S-D2

ER 80S-D2 0,8MM

| Type   | KG/unit | EANCode       |
|--------|---------|---------------|
| BS-300 | 15      | 8720663416711 |
| D-200  | 5       | 8720663416674 |

ER 80S-D2 1,0MM

| Type   | KG/unit | EANCode       |
|--------|---------|---------------|
| BS-300 | 15      | 8720663406316 |

ER 80S-D2 1,2MM

| Type   | KG/unit | EANCode       |
|--------|---------|---------------|
| BS-300 | 15      | 8720663416735 |