



CEWELD ER 80S-D2 Tig

TYPE	Solid welding wire for Tig 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	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						
CLASSIFICATION	AWS	A 5.28: ER 80S-D2					
	EN ISO	21952-A: W Z4Mo					
	EN ISO	636-B: W 57A 4 M31					
	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, OPTIM 500ML, PAS 65 us, PAS 70 us, Dilimax 500, Dilimax 550, AISI 4130, 4140, 8630 and ASTM grades A182 Grade F22						
APPROVALS	CE						
WELDING POSITIONS	 PA  PB  PC  PD  PE  PF  PG						
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si		Mn		Mo	
	0.08	0.7		1.8		0.5	
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} MPa	R _m MPa	A ₅ (%)	RT	Impact Energy (J) ISO-V	
	As Welded /1h	540	620	24	150	-40°C	-50°C
						55	47
REDRYING TEMPERATURE	Not required						
GAS ACCORDING EN 14175	I1						



CEWELD ER 80S-D2 Tig

ER 80S-D2 TIG 1,6 X
1000MM

Type	KG/unit	EANCode
Tube	5	8720663416681

ER 80S-D2 TIG 2,0MM

Type	KG/unit	EANCode
Tube	5	

ER 80S-D2 TIG 2,4 X
1000MM

Type	KG/unit	EANCode
Tube	5	8720663416698

ER 80S-D2 TIG 3,2 X
1000MM

Type	KG/unit	EANCode
Tube	5	8720663416704