

KC-80D2

For 0.5%Mo heat-resistant steel

Classifications

AWS A5.28-05	: ER80S-D2
KS D 7120	: YGM-C
JIS Z 3317	: YGM-C

Description

- For butt and fillet welding of structural steels, boiler and pressure vessels such as 0.5%Mo heat-resistant steel
- Excellent property of heat-resistant due to alloying Mo
- Superior tensile strength and impact values after PWHT
- Beautiful weld appearance due to excellent arc stability and low spatter

Typical chemical composition of wire (%)

C	Si	Mn	P	S	Mo
0.08	0.58	1.85	0.014	0.009	0.46

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) -30°C	Remarks
AWS A5.28	min. 470	min. 550	min. 17	≥ 27	CO ₂
Example	610	690	25	60	CO ₂

Operating data

	Dia.(mm)	1.2	1.4
Current (Amp.)	Flat (PA/1G)	120 ~ 350	150 ~ 400
	Vertical (PF/3G)	80 ~ 180	100 ~ 250
	Overhead (PE/4G)	80 ~ 180	100 ~ 250

Polarity and Shielding gas

- DCEP (DC+)
- CO₂ : 100% CO₂ (15~25ℓ /min.)