

Classifications

AWS A5.28-05	: ER80S-D2
KS D 7140	: YGTM
JIS Z 3316	: YGTM

Description

- For carbon and low alloy steels such as AISI 4130
- Where the tensile strength provided by plain carbon steel rod are inadequate.
- This rod is designed to give high strength welds on high sulfur bearing (free-machining) steels or medium carbon steels.
- This rod contains additional amounts of manganese and silicon which produces weld deposits which have high ductility, excellent impact values and tensile strength.

Typical chemical composition of rod (%)

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	Ar
Example	610	690	23	180	Ar

Operating data

Dia.(mm)	2.4~3.2
Current (Amp.)	200 ~ 300

Polarity and Shielding gas

- DCEN (DC-)
- Ar : 100%Ar (15~25ℓ/min)