SG 80 S-D2

Standards

TS EN ISO 14341-A	: G 4Mo
EN ISO 14341-A	: G 4Mo
TS EN ISO 14341-A	: W 4Mo
EN ISO 14341-A	: W 4Mo
AWS A5.28	: ER 80 S-D2

Chemical Composition of Welding Wire % (Typical)

C	Si	Mo	Mn
0.10	0.65	0.5	1.8

Mechanical Properties

Yield Strength (N/mm^2)	Tensile Strength (N/mm^2)	Impact Strength (ISO-V/-30°C)	Elongation ($(L_o=5d_o)$ (%))
min. 470	550 - 680	min. 47 J	min. 20

Typical Base Material Grades

- S355J2G3, L320-L415NB, L320MB-L415MB, P255G1TH, P235GH-P355GH, 16Mo3, 17MnMoV6-4, 20MnMoNi5- 5, 20MnMoNi4-5, GE240-GE300, 22Mo4, S255N-S460N, P255NH-P460 NH

Features and Applications

- Copper coated for GMAW and TIG welding in boiler pressure vessel, pipework and crane construction as well as in structural steel engineering
- High quality, very tough deposit of high crack resistance and non-aging
- Recommended for service in temperature range -45°C (TIG) or -40 °C (GMAW) to +550 °C.
- Good copper bonding with low total copper content
- Very good welding and flow characteristics
- Preheating interpass and postweld heat treatment as required by base metal
- Shielding gases: MAG; Ar+CO_2 mix gases, TIG; pure Ar gas can be used

Welding Positions

Current Type

TIG D.C.(-) / MAG D.C.(+)

Operating Data

Product Code		Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
BS 300	D 300				BS/D/300
3010203050	3010203075	0.8	0.030”	15	D 200
3010203052	3010203077	1.0	0.040”	15	D 100
3010203054	3010203079	1.2	0.047”	15	ECO PACK
3010203055	3010203081	1.6 (0,6,0.9, 1.14,1.4)	0.062”	15 (1,5,15,18,50,250,400)	BIG PACK
3010300281		1,60 x 1000	1/16 x 39”	5	Carton Box
3010300282		2,00 x 1000	5/64 x 39”	5	
3010300283		2,40 x 1000	3/32 x 39”	5	
3010300284		3,20 x 1000	1/8 x 39”	5	
3010300285		4,00 x 1000	5/32 x 39”	5	
3010300286		5,00 x 1000	3/16 x 39”	5	

Approvals: SG80 S-D2: CE, SEPRO