



AUTOTHERME 80S-D2

CODIFICATION: **AWS :** SFA 5.28 ER80S-D2
 EN ISO : 14341-B G 55A 3 M13 4Mo

CHARACTERISTICS AND APPLICATIONS:

Autotherme 80S-D2 is a copper-coated solid wire for GMAW, available in bright finish. The wire gives stable arc, smooth welding performances and deposits radiographic quality welds. It is recommended for welding of molybdenum (~ 0.5%) containing high strength fine-grained structural steels. The wire also is suitable for welding of penstock pipe-line, fabrication of earth moving equipments, etc. where high tensile strength property is desired from the weld metal. Suitable for welding of ASTM steels: SA-455/SA-455M, Gr.60, Gr.65 steels of SA-515/SA-515M, Gr.60, Gr.65 steels of SA-516/SA-516M, Class 1 of A, B, C, D grades of SA-533/SA-533M, etc.

TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

Element	C	Mn	Si	S	P	Mo	Cu
%	0.075	1.78	0.55	0.014	0.015	0.45	0.15

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS	YS	Elongation	CVN Impact Strength
(MPa)	(MPa)	(L=5d) %	At minus 30°C (Joules)
680	560	22	55

WELDING PARAMETER: DC(+)

Diameter	Flat	
	Volt, V	Current, A
1.2 mm	27-32	300-360
1.6 mm	25-30	340-420

SHIELDING GAS: Argon/ 1-5% O₂

WELDING POSITION: H, F, VU, OH

APPROVAL: CE

PACKING:

STANDARD SIZE	1.2 mm & 1.6 mm.
QUANTITY	15.0 kg wire, layer wound in a plastic spool that conforms to DIN-8559 SD-300.

- Note:** 1. The product satisfies the requirement of AWS SFA 5.28 ER90S-D2 class also.
2. Please check availability and minimum order quantity before placing the order.