

Low alloy solid wire

Classification

AWS A5.28-96 : ER80S-G

General description

Solid wire for welding of weather resisiting steels

Shielding gases (acc. EN 439)

GTAW	I1	Inert gas Ar (100%)
GMAW	M21	Mixed gas Ar+ >5 to 25% CO ₂
	C1	Active gas 100% CO ₂

Approvals

	DB
GMAW	+

Chemical composition (w%), typical, wire / rod

C	Mn	Si	Ni	Cu
0.1	1.4	0.75	0.8	0.3

Chemical composition (w%), typical, wire / rod

Mechanical properties, typical, all weld metal

	Process	Shielding gas	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J) -20°C
Typical values	GTAW	I1	AW	570	620	26	80
	GMAW	M21	AW	570	620	26	80

Materials to be welded

Steel	Code	Type
Weather resisting steels like:	EN 10155	S 235 J 0 W S 235 J 2 W S 355 J 0 W S 355 J 2 W S 355 K 2 G 1 W

Packaging

Process	Unit	Sizes (mm)		
		1.0	1.2	2.4
GTAW	5 kg tube			X
GMAW	15 kg spool B300	X	X	

Other sizes and packaging on request