

TALARC D2

CLASSIFICATION

AWS SPECIFICATIONS	EN SPECIFICATIONS
AWS A 5.28: ER80S-D2	EN ISO 14341-A: G 50 5 M G4Mo

ALLOY TYPE

Low-alloy copper-coated solid wire with 0.5% Mo content for welding high strength steels.

APPLICATIONS

Low-alloy copper-coated solid wire with 0.5% Mo content designed for welding low-alloy steels with high tensile strength and creep-resistant steels. Suitable for pipelines and pressure vessels with operating temperatures of about 500°C. Also finds applications for the repair of medium strength steel castings. Good impact strength at low temperatures. To be used under the shield of Ar+CO₂.

TYPICAL CHEMICAL COMPOSITION OF WIRE

C %	Mn %	Si %	S %	P %	Cr %	Ni %	Mo%	Cu %
0.08	1.80	0.70	0.01	0.01	-	-	0.50	0.12

TYPICAL MECHANICAL PROPERTIES

GAS		Yield strength	Tensile strength	Elongation on % 5d	Impact energy (Charpy V)				
		Rs	Rm	A 5d	+ 20°C	0°C	-20°C	-40°C	-60°C
		(N/mm ²)	(N/mm ²)	%	(Joule)	(Joule)	(Joule)	(Joule)	(Joule)
MIX	as welded	560	650	22	150	120	90	-	-

WELDING GUIDELINES

Preheat and interpass temperature 150°C. PWHT is not required.

TECHNICAL INFORMATION

Gas: Mix Ar- CO₂ (EN 14175)
Welding position: all positions



WELDING PARAMETERS

Current	DC + Reverse polarity		
Diameter (mm)	0.9	1.2	
Volts (V)	17 ÷ 30	18 ÷ 34	
Intensity (A)	70 ÷ 240	100 ÷ 360	

Diam.	15kg Spool
0.9mm	INMD209
1.2mm	INMD212

TALARC Pty Ltd
10-16 Syme St
Brunswick, Vic 3056
Ph. +61 3 9388 0588 Fax: +61 3 9388 0710
W: www.talarc.com E: sales@talarc.com