

TALARC D2 TIG

CLASSIFICATION

AWS SPECIFICATIONS	EN SPECIFICATIONS
AWS A 5.28: ER80S-D2	EN ISO 636-B: W4M31

ALLOY TYPE

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

APPLICATIONS

Low-alloy copper-coated tig rod 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.

TYPICAL CHEMICAL COMPOSITION OF WIRE

C %	Mn %	Si %	S %	P %	Cu %	Ni %	Cr %	Mo %
0.08	1.90	0.70	0.010	0.010	0.15	-	-	0.50

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	-50°C
		(MPa)	(MPa)	%	(Joule)	(Joule)	(Joule)	(Joule)	(Joule)
Argon	as welded	570	660	22	200	-	-	-	-

WELDING GUIDELINES

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

TECHNICAL INFORMATION

Gas: Argon 100% (EN ISO 14175)

Welding position: all positions



WELDING PARAMETERS and PACKAGING DATA

Diameter (mm)	1.6	2.4
Length (mm)	1000	
Carton	5 Kg	
Current	DC - Straight (-) polarity	

CDiam.	5kg Tube
1.6mm	INTD216
2.4mm	INTD224

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