

TALWELD 80D-2

CLASSIFICATION

AWS SPECIFICATION	AS/NZS ISO SPECIFICATION
AWS A5.28: ER80S-D2	AS/NZS ISO 14341 B: G 55A 5U M G4M31

ALLOY TYPE

Low-alloy copper-coated solid wire with 0.5%Mo content

APPLICATIONS

A copper-coated Manganese-Molybdenum solid wire designed for butt and fillet welding low-alloy steels with Tensile Strength in the range 550 to 620 MPa. The wire contains special elements to promote excellent bead appearance.

TYPICAL CHEMICAL COMPOSITION OF WIRE

C%	Mn%	Si%	S%	P%	Cr%	Ni%	Mo%	Cu%
0.09	1.85	0.62	0.008	0.015	-	-	0.50	0.12

TYPICAL MECHANICAL PROPERTIES

Shielding Gas		Yield strength	Tensile strength	Elongation on 5d	Impact energy (Charpy V)
					- 30°C
		MPa	MPa	%	(Joule)
Ar + 20% CO ₂	As welded	650	710	26	100
100% CO ₂	As welded	620	697	24	50

WELDING GUIDELINES

Preheat and interpass temperature 150 ± 15 °C. PWHT is not required.

TECHNICAL INFORMATION

Gas: Mix Ar-CO₂ or 100% CO₂

Welding position: PA, PB



WELDING PARAMETERS

Current	DC+ Reverse polarity	
Diameter(mm)	0.9	1.2
Volts(V)	22 - 28	28 - 36
Intensity(A)	160 - 260	260 - 350

Diam.	15kg Spool	Ball pac (drum)
0.9mm	TALWELD-D209	TALWELD-D209250
1.2mm	TALWELD-D212	TALWELD-D212300

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