



CEWELD ER 80S-D2 Tig

TYPE	Solid welding rod for Tig welding of steel grades up to 550.(ER 80S-D2, G4Mo) MPa yield strength							
APPLICATIONS	CEWELD® ER 80S-D2 Tig is for welding high-strength steels up to 550 MPa yield strength. Mainly in the following areas: Steel construction, shipbuilding, pressure vessels, mechanical engineering, pipe work, offshore, crane building, heavy transport, lifting equipment respecting the NACE requirements							
PROPERTIES	CEWELD ER80S-D2 Tig is a copper coated welding rod for welding of high strength steels, used predominantly after stress relieving. May find its use for joining creep resistance steels up to about 500°C but the CEWELD SG MO wire would be the more usual choice							
CLASSIFICATION	AWS	A 5.28: ER 80S-D2						
	EN ISO	21952-A: W Z4Mo, 636-B: W 57A 4 M31						
	F-nr	6						
	FM	1						
SUITABLE FOR	Reh ≤ 500 MPa ISO 15608: 1.2, 1.3, 2.1, 9.2 1.5637, 1.6217, 1.6228, 1.0044-1.09821.0035 - 1.0570, 1.0345, 1.0425, 1.0481, 1.0308 - 1.0581, 1.0307 - 1.0582, 1.0440, 1.0472, 1.0475, 1.0416 to 1.0551 10Ni14, 12Ni14, 13MnNi6-3, 15NiMn6, S275N-S460N, S275NL-S460NL, S275M-S460M, S275ML-S460ML, P275NL1-P460NL1, P275NL2-P460NL2 ASTM A 203 Gr. D, E; A 333 Gr. 3; A334 Gr. 3; A 350 Gr. LF1, LF2, LF3; A 420 Gr. WPL3, WPL6; A 516 Gr. 60, 65; AA 529 Gr. 50; A 572 Gr. 42, 65; A 633 Gr. A, D, E; A 662 Gr. A, B, C; A 707 Gr. L1, L2, L3; A 738 Gr. A; A 841 A, B, C NFA 35-207: A510PP1 – A550PP2 NFA 36208: 3.5 Ni 285 ct 355 (12N14) OPTIM 500ML, PAS 65 us, PAS 70 us, Dilimax 500, Dilimax 550, Weldox 500							
APPROVALS	CE							
WELDING POSITIONS								
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si		Mn		Mo		
	0.08	0.7		1.8		0.5		
MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness
	As Welded	540	620	24	RT	-40°C	-50°C	HRc
					150	55	47	
REDRYING	Not required							
GAS ACC. EN ISO 14175	I1							



CEWELD ER 80S-D2 Tig

ER 80S-D2 TIG 1,6 X
1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663416681

ER 80S-D2 TIG 2,4 X
1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663416698

ER 80S-D2 TIG 3,2 X
1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663416704