

# TIGFIL 80S-D2

## Classification

AWSA/SFA 5. 28 : ER 80S-D2

Identification: AWS classification embossed at one end of the wire.

## Characteristics

A copper coated GTAW/TIG filler rod having Mn and 0.5Mo.

## Typical Applications

For welding of Mn-0.5 Mo steels.

### Wire Chemistry, wt % (Typical)

C	Mn	Si	S	P	Mo
0.07-0.12	1.60-2.10	0.50-0.80	0.025 max	0.025 max	0.40-0.60

Properties of weld metal with 100% Argon gas shielding **Current Condition: DC (-)**

### All Weld Mechanical Properties As welded condition

UTS MPa	550 min	CVN Impact value J
Yield strength MPa	480 min	at - 30°C
Elongation % (L=4xd)	22 min	30 Min
The chemistry & mechanical properties of the weld metal will vary with the type of shielding gas used.		

### Packing Data

Dia (mm)	1.6	2.0	2.5
Length (mm)	1000	1000	1000
Primary Tube (Kg)	5	5	5
No. of Tubes	4	4	4
Secondary Cartons (Kg)	20	20	20

TIGFIL Wires are sealed in polyethylene bags and then packed in primary tubes.

TIGFIL Wires are also available in 5 Kg PSLW spools in 0.8, 1.0 and 1.2 mm sizes for orbital GTAW/TIG welding.

AUTOMIG 80S D2, in spool form, available for GMAW process, on demand.



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