

Coreweld 80-D2

JIS Z3313 YFW-A602M

Flux
CORED
WIRES

Description

- Coreweld 80 D2 is a metal cored wire equivalent to ER80S-D2 solid wires and is a direct substitute for them.
- Some of the benefits of Coreweld 80 D2 are higher deposition rates, better wetting action, and the absence of copper coating on the wire. Coreweld 80 D2 was developed for HSLA steels. This product is capable of single or multiple pass welding.

Shielding Gas : 100%CO₂, 75%Ar/25%CO₂ or 98%Ar/2%O₂

Typical Mechanical Properties of All Weld Metal (All Weld Metal Using 75%Ar/28% CO₂)

Yield Point N/mm ² {kgf/mm ² }	Tensile Strength N/mm ² {kgf/mm ² }	Elongation (%)	Impact Value J(kgf · m)			PWHT
			0 °C	-30 °C	-40 °C	
531 {54}	621 {63}	26	100 {10.2}	46 {4.7}	31 {3.2}	As-Welded
531 {54}	627 {64}	26	80 {8.3}	34 {3.5}	-	635°C x8hr

Typical Undiluted Weld Metal Analysis %

C	Mn	Si	P	S	Mo
0.09	1.20	0.25	0.010	0.018	0.49

* Shielding Gas : 75%Ar/25%CO₂