

**TIG wire and rod for Mn-Mo and Mn-Mo-Ni steel**

<b>Features:</b>	• Applied for ASTM A533 Type A, B, C, D and equivalents
<b>Classification:</b>	AWS A5.28 ER80S-G
<b>Shielding Gas:</b>	Ar
<b>Identification color:</b>	1st Silver gray
<b>Polarity:</b>	DCEN

**Packaging data**

ø mm	Tube		
	kg	Length mm	g/piece
1.2	5	1,000	9
1.6	5	1,000	16
2.0	5	1,000	25
2.4	5	1,000	35
<b>Volume mm</b>	40W, 35H, 1015L		

**Composition (wire mass%)**

	Typical	Guaranty <sup>a</sup>
<b>C</b>	0.10	0.12
<b>Si</b>	0.39	0.20~0.60
<b>Mn</b>	1.52	1.20~1.80
<b>P</b>	0.003	0.025
<b>S</b>	0.007	0.025
<b>Ni</b>	0.62	0.40~0.80
<b>Mo</b>	0.49	0.40~0.60
<b>Cu</b>	0.16	0.35

Note: <sup>a</sup>Single values are maximum.**All-weld mechanical properties**

	Typical	Guaranty
<b>0.2%YS (MPa)</b>	520	469min.
<b>TS (MPa)</b>	590	552min.
<b>EI on 4d (%)</b>	31	19min.
<b>IV -12°C (J)</b>	290	-
<b>PWHT (°C×h)</b>	620x1	620±15x1

**Approvals**

<b>TÜV</b>	MG
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