

## TIG welding rod and wire

<b>Features:</b>	▪ Suitable for 550 to 590MPa tensile strength steel
<b>Classification:</b>	AWS A5.28 ER80S-G
<b>Shielding gas:</b>	Ar
<b>Identification color:</b>	1st White
<b>Polarity:</b>	DCEN

## Packaging data

φ mm	Tube		
	kg	Length mm	g/piece
1.6	5	1,000	16
2.0	5	1,000	25
2.4	5	1,000	35
3.2	5	1,000	63
<b>Volume mm</b>	40W, 35H, 1015L		

## Composition (wire mass%)

	Typical	Guaranty <sup>a</sup>
<b>C</b>	0.08	0.10
<b>Si</b>	0.74	0.30~0.85
<b>Mn</b>	1.38	1.15~1.65
<b>P</b>	0.007	0.020
<b>S</b>	0.006	0.020
<b>Ni</b>	0.03	0.60
<b>Mo</b>	0.52	0.25~0.65
<b>Cu</b>	0.16	0.50

## Welding parameters (A)

φ mm	Rod
1.6	60~220
2.0	80~240
2.4	100~260
3.2	150~300

Note: <sup>a</sup>Single values are maximum.

## All-weld mechanical properties

	Typical		Guaranty
<b>0.2%YS (MPa)</b>	540	530	420min.
<b>TS (MPa)</b>	660	640	552min.
<b>EI on 4d (%)</b>	28	26	18min.
<b>IV -20°C (J)</b>	180	98	27min.
<b>PWHT (°C×h)</b>	AW	620x1	AW & 620±15x1