

ZULFI SW ER80S-D2

CLASSIFICATION

AWS A5.28 ER80S-D2

APPROVALS

ABS
BV
DNV
LRS

GRADE

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PROPERTIES

ZULFI ER80S-D2 is a copper coated precision layered wire depositing a C-1.40Mn-0.50Mo weld metal. Welding metal with 1.40Mn and 0.45Mo makes this electrode suitable for welding high strength steel. Suitable for use with Argon shielding gas, CO2 and Mixed gas.

APPLICATIONS

The welding deposits of this wire have moderately high strength with adequate low temperature toughness. A pre-heat and interpass temperature of not less than 300°F is required during welding. ASTM A588 weathering steel requiring good atmospheric corrosion resistance, NACE applications and shipping grade like AH 40, DH 40 and EH40.

CHEMICAL ANALYSIS [TYPICAL VALUES IN %]

CONDITION	C	Mn	Si	P	S	Ni	Mo	Cr
Wire	0.10	1.75	0.60	0.015	0.015	0.08	0.50	0.03
Weld metal (CO2)	0.08	1.40	0.30	0.014	0.013	0.07	0.48	0.01

CURRENT CONDITION & WELDING POSITION

DC+

ALL-WELD METAL MECHANICAL PROPERTIES

CONDITION	YIELD STRENGTH (MPa)	TENSILE STRENGTH (MPa)	ELONGATION %	IMPACT STRENGTH
As welded (CO2)	≥ 480	550 - 680	≥ 22	60J at -40 °C

PACKING DATA

DIAMETER (MM)	VOLTAGE (V)	CURRENT (A)	GAS FLOW RATE (LPM)	WEIGHT PER TUBE (KG)
0.80	17-27	80-250	12-18 (100% CO ₂) 17-22 (ArCO ₂)	15
1.0	18-30	100-350		15
1.20	20-34	120-400		15
1.60	22-36	150-450		15