

KC-80D2

For 0.5%Mo heat-resistant steel

Classifications

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|--------------|------------|
| AWS A5.28-05 | : ER80S-D2 |
| KS D 7120 | : YGM-C |
| JIS Z 3317 | : YGM-C |

Description

- For butt and fillet welding of structural steels, boiler and pressure vessels such as 0.5%Mo heat-resistant steel
- Excellent property of heat-resistant due to alloying Mo
- Superior tensile strength and impact values after PWHT
- Beautiful weld appearance due to excellent arc stability and low spatter

Typical chemical composition of wire (%)

| C | Si | Mn | P | S | Mo |
|------|------|------|-------|-------|------|
| 0.08 | 0.58 | 1.85 | 0.014 | 0.009 | 0.46 |

Typical mechanical properties of all-weld metal

| | Y.S (MPa) | T.S (MPa) | El. (%) | IV (J) -30°C | Remarks |
|-----------|--------------|--------------|------------|-----------------|-----------------|
| AWS A5.28 | min. 470 | min. 550 | min. 17 | ≥ 27 | CO ₂ |
| Example | 610 | 690 | 25 | 60 | CO ₂ |

Operating data

| Current (Amp.) | Dia.(mm) | 1.2 | | 1.4 |
|-------------------|------------------|--------------|-----------|-----------|
| | | Flat (PA/1G) | 120 ~ 350 | 150 ~ 400 |
| Vertical (PF/3G) | Overhead (PE/4G) | 80 ~ 180 | 100 ~ 250 | |
| | | 80 ~ 180 | 100 ~ 250 | |

Polarity and Shielding gas

- DCEP (DC+)
- CO₂ : 100% CO₂ (15~25ℓ /min.)