

CARBOROD 80S-D2

TIG Rods C-Mn steels and low-alloy steels

Carborod 80S-D2 is a TIG rod suitable for welding 0,5 Mo steels and high temperature resistant steels. The weld deposit is resistant to cold cracking.

Classification

AWS A5.28: ER 80S-D2

Approvals

TÜV

Grades

see Appendix, Classification Society Approvals, for details pag. 521

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.09	1.90	0.60	≤ 0.020	≤ 0.020	-	0.15	0.50	-	-	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) -20°C	Hardness
PWHT 620°C x 1h	≥ 470	≥ 550	≥ 22	≥ 47	-

Gas test: Acc. To EN 439: I1(Arcal1)

Shielding Gas: Acc. To EN 439: I1(Arcal1)

Materials

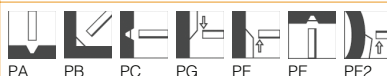
S(P)235-S(P)460, 16Mo3

Storage

Keep dry and avoid condensation

Current condition and welding position

DC-



Packaging data: Tube 5 kg

Diameters (L: 1000 mm)	1,2	1,6	2,0	2,4	3,2	
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Further forms of delivery on request.