

Specifications:

AWS A5.28
ASME SFA 5.28
AWS ER80S-D2; ER90S-D2

Properties:

Tensile Strength: 80,000 psi min.
Yield Strength: 68,000 psi min
Elongation: 17% min.

Description:

WT 80S-D2 is a mild steel solid wire that contains molybdenum for increased strength and higher levels of silicon and manganese which provides a good rust and scale tolerance as well as providing good wetting. It is best suited for pipelines and pressure vessels with temperatures of around 930°F. WT 80S-D2 has increased impact strength at low temperatures. It is suitable for both single and multiple pass welding of low alloy steels and higher strength steels in both the as welded and PWHT conditions

Available in multiple sizes and diameters.

Chemical Composition (Wt%):

Si	Mn	S	P	C	Cu	Mo	Ni
0.5-0.80	1.6-2.1	0.025	0.025	0.07-1.12	0.5	0.4-0.6	0.158

Note: Single values are maximum unless otherwise noted

Maintaining a proper welding procedure, including pre-heat and interpass temperatures, may be critical depending on the type and thickness of material being welded.

CAUTION: Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standards A49.1, "Safety in Welding and Cutting," published by the American Welding Society, 8669 NW 36 Street, #130, Miami, FL 33126: OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210.