

Low alloy solid wire

Classification

AWS A5.28

:ER80S-G

General Description

Solid wire for welding of weather resisiting steels

Shielding gases (acc. EN 439)

GTAW	I1	Inert gas Ar 100%
GMAW	M21	Mixed gas Ar+ >5-25% CO ₂
	C1	Active gas 100% CO ₂

Chemical composition (w%), typical, all weld metal

C	Mn	Si	Ni	Cu
0.1	1.4	0.75	0.8	0.3

Mechanical properties,all weld metal

	Process	Shielding gas	Condition	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation (%)	Impact (ISO), J
							-20°C
Typical values	GTAW	I1	AW	570	620	26	80
after welding	GMAW	M21	AW	570	620	26	80

Materials to be welded

Steel	Code	Type
Weather resisting steels	EN 10155	S 235 J 0 W S 235 J 2 W S 355 J 0 W S 355 J 2 W S 355 K 2 G 1 W

Packaging,available sizes and identification

Process	Unit:	Sizes, mm		
		1.0	1.2	1.4
GTAW	5 kg tube			X
GMAW	15 kg spool B300	X	X	

Other sizes and packaging on request

Identification

Imprint: Revis®80S-G

Tip colour:

Revis®80S-G: rev.EN 20