

FOR HEAT-
RESISTING STEEL

AWS ER80S-D2
JIS YGM-C
KS YGM-C

KG-80D2

Typical applications

Butt and fillet welding of construction equipment, boiler, low alloy steels, and 0.5%Mo alloy steel.

Characteristics on Usage

- ① This wire is used for welding steels employed at elevated temperatures up to 500°C.
- ② Where joint thickness is critical, it is important to apply the correct preheating and interpass temperatures.

Typical chemical composition of wire (%)

C	Si	Mn	Mo
0.08	0.58	1.85	0.46

Typical mechanical properties of all-weld-metal

Shielding Gas	Y · P N/mm ² {kgf/mm ² }	T · S N/mm ² {kgf/mm ² }	El (%)	Charpy V-notch J {kgf · m} (-29°C)
Ar+2%O ₂	610 {62}	690 {70}	23	60 {6}

Sizes available and recommended currents (DC wire⊕)

Dia.	(mm)	0.9	1.0	1.2	1.4	1.6
Amp.	F	50~180	80~250	120~350	140~400	220~450
	V&OH	50~120	60~150	70~200	100~250	120~250

Package

Dia.	(mm)	0.8	0.9	1.0	1.2	1.4	1.6
Spool	(kg)	5, 15, 20					
Pailpack	(S)	200, 250		250, 300,		-	
Pailpack	(B)	-		350,400,450			

Approved by