FOR HEAT-RESISTING STEEL

AWS ER80S-D2
EN G4Mo
JIS YGT M

T-80D2

Typical applications

This rod uses TIG welding on carbon and low alloy steels such as AISI 4130 where the tensile strength provided by plain carbon steel rod are inadequate.
Welding of farm implements, automotive parts, pipes, light-gauge steels, low alloy steels such as AISI 4130 and high yield strength steels such as T-1.

Characteristics on Usage

① This rod is designed to give high strength welds on high sulfer bearing(free-machining) steels or medium carbon steels.
② This rod contains additional amounts of manganese and silicon which, produces weld deposits which have high ductility, excellent impact values and tensile strength.

Typical chemical composition of rod (%)

C	Si	Mn	Mo
0.08	0.63	1.85	0.50

Typical mechanical properties of all-weld-metal

Y · P N/mm² {kgf/mm²}	T · S N/mm² {kgf/mm²}	El (%)	Charpy V-notch J {kgf · m} (-29℃)
610 {62}	700 {71}	22	180 {18}

Approved by