

GTAW Solid Wire for High Tensile Strength Steel

TG-80

Classification

AWS	A5.28	ER80S-G
JIS	Z3316	W 55 A 2 3M1T
EN	636-A	W 50 2 W0
GB	T 8110	ER50-G

Shielding Gas: Ar

Applications and Features

- (1) TG-80 is suitable for 590~780N/mm² grade steel.
- (2) It is used for penetration of root pass.
- (3) Ideal for welding in Mo and Mn-Mo high tensile steel.

Welding Instruction

Please refer to Appendix C.

Typical Chemical Composition of Weld Metal (wt. %)

C	Si	Mn	P	S	Mo
0.050	0.70	1.86	0.010	0.008	0.40

Typical Mechanical Properties of Weld Metal

Tensile Strength N/mm ² (kgf/mm ²)	Yield Strength N/mm ² (kgf/mm ²)	Elongation %	Charpy V-Notch °C	J (kgf -m)
670(68.3)	590(60.2)	28	0	205(20.9)
			-20	174(17.8)

Size and Suggested Operating Range (DC+)

Diameter (mm)	1.2	1.4	1.6	2.0	2.4	2.6	3.2	4.0	4.8	5.0
Length (mm)	1000									