

# GMAW Wires for Low Alloy Steel

## KM-80SD2

### Classification

AWS	A 5.28/A5.28M	ER80S-D2/ ER55S-D2
JIS	Z3312	G 55 A 3 C 4M3T
EN	14341-A	G 46 3 C1 4Mo
GB	T8110	ER55-D2

Shielding Gas: 100% CO<sub>2</sub>

### Applications and Features

- (1) Suitable for welding 550N/mm<sup>2</sup> grade steel.
- (2) 0.5% Mo to provide higher strength in both the as welded and stress relieved conditions.
- (3) Ideal for welding high tensile pipe and earthmoving and construction equipment.

### Welding position



### Welding Instruction

Please refer to Appendix B.

### Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	P	S	Mo
0.08	0.67	1.54	0.022	0.006	0.42

### Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm <sup>2</sup>	N/mm <sup>2</sup>	%	°C	J
667	578	25	-29	78

### Size and Suggested Operating Range (DC+)

Diameter (mm)		0.8	0.9	1.0	1.2	1.4	1.6
Current (A)	H/HF	50~180	50~200	50~220	80~350	100~470	200~500
	V-up	50~100	50~140	50~140	50~140	100~180	-
	OH	50~100	50~120	50~120	50~160	-	-
	V-down	50~100	50~200	-	-	-	-