

Normalised designation : ISO 14341-A: G4Mo

AWSA5.28: ER80S-D2

### Properties :

Full copper wire for gas-protected welding of low-carbon steels allied with molybdenum (0.5% MB), resistant up to temperatures of 500 c.

**Weldable steels:** Steels and tubes for pressure machines and boilers

|                   |   |
|-------------------|---|
| NF A 36-206 :     | 15D3 - 18MD4 -05  |
| DIN 17155-17245 : | HI - HIII - GS C 25 17 Mn4  |
| DIN 17175-17102 : | 19 Mn5 - 15Mo3 - GS22Mo4 - St 35.8 - St 45.8 - 17 Mn4 - StE255 - StE420 |
| BS :              | BS 1504 - Gr 245 - BS 3100 - Gr B1 - BS 3606 - Gr 243 - Gr 245          |
| ASTM :            | A335 Gr P1 - A352 GrLC1 - A204 Gr A et B - A 155 Gr CM 65/70            |

### Mechanical properties :

Re = 500 MPa\*

Rm = 620 MPa\*

A5 = 25 %

KV > 140 J at + 20 °C

(\*after TTh 650°C / 1h)

**Parameters and conditions:** MIG - Continuous Current (electrode)

| Gaz (ISO 14175)  | Ø (mm) | Paramètres de soudage |         |
|--|--------|-----------------------|---------|
|  |        | Arc pulsé (A)         | (V)     |
| M21 (Ar/CO <sub>2</sub> )<br>C1 (100% CO <sub>2</sub> )<br>12 - 15 L/min | 1      | 150 - 170             | 25 - 28 |
|  | 1,2    | 180 - 250             | 26 - 28 |

**Packaging :** coil 15 kg

**Responsibility:** The purpose of this document is to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for the applications for which it is intended. We reserve the right to modify the characteristics of its products without notice. Descriptions, illustrations and features are provided as an indication and cannot be the responsibility of our company. Smoke: View information on the Security Data Sheet available on request