

AK ER80S-D2

Description: Type ER80S-D2 filler metal contains a high level of deoxidizers (manganese & silicon) to control porosity when welding with Co 2 as the shielding gas, and molybdenum for increased strength.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Cr	Mo	Ni	Cu
Requirement	0.07-0.12	0.50-0.80	1.60-2.10	0.025	0.025	—	0.40-0.60	0.15	0.50
Actual Result	0.08	0.57	1.71	0.005	0.009	—	0.47	0.005	0.14

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥550	≥470	≥17	≥54J (-30℃)
Actual Result	600	530	22	126 112 106