

AK ER80S-G

Description: A low fuming bronze welding wire, suitable for brass welding, also braze welding of copper, steel and cast iron.

Application: Used to weld brass, copper, steel and cast iron products

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Cr	—	—	—
Actual Result	0.08	0.54	1.64	0.006	0.012	0.41	—	—	—

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Actual Result	665	585	24.5	113J(-40℃)

Recommended welding parameters:

Diameter/ mm		0.8	1.0	1.2
Welding current/A	F/H	50-180	80-250	100-360
	V/OH	50-100	70-160	80-220