



MIG F60

Old reference: MIG 80SD2

Classification

AWS A5.28 : ER80S-D2

ISO 14341-A : G 50 5 M21 4Mo

Description & Applications

Copper coated solid wire alloyed with Molybdenum (0.5% Mo) for gas (Ar + CO₂) metal arc welding of creep resisting steels used at service temperatures up to 500°C.

Main applications: For piping systems, boilers...

Base materials:

Steels and pipes for boiler and pressure vessels:

NF A 36-206	DIN 17155-17245	DIN 17175-17102	BS	ASTM
15D3	HI	19Mn5	BS 1504 Gr 245	A335 Gr P1
18MD4-05	HIII	15Mo3	BS 3100 Gr B1	A352 GrLC1
	GS C 25 17 Mn4	GS22Mo4 St35.8	BS 3606 Gr 243, 245	A204 Gr. A et B
		St 45.8		A155 Gr CM 65/70
		17Mn4		
		StE255		
		StE420		

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	Al	Ti+Zr	V	P	S	O/T
Min	0.07	0.50	1.60			0.40							
Max	0.12	0.80	2.10	0.15	0.15	0.60	0.35	0.02	0.15	0.03	0.025	0.025	0.50
Type	0.08	0.70	1.8	0.10	0.05	0.50	0.18	0.01	0.005	0.01	0.01	0.01	<0.50

All Weld Metal Mechanical Properties

	R _e (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
Min	500	560	18	-50°C >47
Max		720		
Type	580	680	21	-50°C 60

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Current (A)	Voltage (V)	
GMAW = +	0.8	60 - 200	16 - 28	ISO 14175: M21 (Ar/CO ₂) 12-15 l/min
	1.0	80 - 260	17 - 32	
	1.2	100 - 360	18 - 34	

FT En-MF01-191113

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