

ES MIG 80S-G

GMAW
ER80S-G

ESWECO
The Art of Welding

Description

ES MIG 80S-G is a 0.5Mo-alloyed, solid wire for the GMAW of creep-resistant steels of the same composition, like those used for pipes in pressure vessels and boilers with a service temperature of up to 500°C. ES MIG 80S-G is taking MAG welding operations to new levels of performance and all-round efficiency, especially in robotic and mechanised welding. Characteristic features include excellent start properties; trouble-free feeding at high wire speeds and lengthy feed distances; a very stable arc at high welding currents; extremely low levels of spatter; low fume emission; reduced contact tip wear and improved protection against corrosion of the wire.

Current

DC+

Classifications

SFA/AWS A5.28	ER80S-G
EN 440	G2Mo
EN 12070	G MoSi

Typical all weld metal composition, %

C	Si	Mn	Mo
0.1	0.5	1.1	0.5

Typical mech. Properties all weld metal

Yield stress, MPa	540
Tensile strength, MPa	630
Elongation, %	25

Charpy V

Test temps, °C	Impact values, J
+20	115
-20	75
-40	55

Welding parameters

Diameter, mm	Wire feed, m/min	Welding current, A	Arc voltage, V
0.8	2.0-10.8	70-170	16-22
1.0	2.7-14.7	80-280	18-28
1.2	3.1-12.0	120-350	20-33
1.6	3.5-12	225-480	26-38