

# **SM-80 (HD)**

**AWS A5.28/ ASME SFA5.28 ER80S-G**

**EN ISO 14341-A-G50 4 M21 Z**



## ❖ Specifications

AWS A5.28/ ASME SFA5.28 ER80S-G  
EN ISO 14341-A-G50 4 M21 Z

## ❖ Applications

MIG/MAG (GMAW) gas shielded welding wires of weather resisting steels such as COR-TEN, Itacor, Patinax, Dillicor and so on

## ❖ Surface treatments

Available with the following surface treatments :

- Copper coated
- Copper free

## ❖ Shielding gas

100 % CO<sub>2</sub>  
Ar + CO<sub>2</sub>

## ❖ Current

GMAW : DC+

## ❖ Chemical composition

Brand Name	C%	Mn%	Si%	Cr%	Ni%	Cu%
SM-80 (HD)	0.08	1.40	0.80	0.30	0.75	0.40

## ❖ Mechanical properties

	YS	UTS	A5d	KV@-20°C	KV@-40°C
	MPa	MPa	%	J	J
SM-80 (HD)	590	660	24	110	70
EN ISO 14341-A-G50 4 M21 Z	≥ 500	≥ 560	≥ 20		≥ 47
AWS A5.28-ER80S-G		≥ 550			

## ❖ Package

SM-80 (HD) (GMAW)	Size(mm)	0.8	1.0	1.2	1.6
	Weight	Spool : 15kg, 16kg, 18kg, 250kg, 350kg, 450kg			