

ST-80D2

Type : TIG

Conformances

AWS A5.28/ ASME SFA5.28 R80S-D2

Applications

- Low-alloy copper-coated solid wire with 0.5% Mo content designed for welding low-alloy steels with high tensile strength and creep-resistant steels
- Suitable for pipelines and pressure vessels with operating temperatures of about 500°C

Features

- Good impact strength at low temperatures

Welding Position

Current

GTAW: DC-

Shielding Gas

Ar

Diameter / Packaging

Diameter	Length mm(in)
mm (in)	5kg (11lbs)
2.0 (5/64)	✓
2.4 (3/32)	✓
3.2 (1/8)	✓

Typical Chemical Composition of the Wire (%)

C	Si	Mn	S	P	Cu	Ni
0.09	0.72	1.84	0.009	0.010	0.15	0.05
Cr	Mo	V	Ti	Al	Zr	Sn
0.11	0.43	0.004	0.001	0.006	0.002	0.008

Typical Mechanical Properties of All-Weld Metal

YS Mpa(lbs/in ²)	TS Mpa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft-lbs)	PWHT
-	718 (104,000)	22.8	-30 (-22)	94 (69)	620°C × 1hr