



# KISWEL

## KISWEL – T-80D2

### Classifications:

AWS A5.28-05: ER80S-D2

### Typical Chemistry Composition of Weld Deposit:

C	Si	Mn	P	S	Mo	Ni
0.07 – 0.12	0.50 – 0.80	1.60 – 2.10	<0.025	<0.025	0.40 – 0.60	<0.15

### Description:

- For carbon and low alloy steels such as AISI 4130, where the tensile strength provided by plain carbon steel wires are inadequate.
- It is designed to give high strength welds on high sulphur bearing (free-machining) steels or medium carbon steels.
- It contains additional amounts of manganese and silicon which produces weld deposits which have high ductility, excellent impact values and tensile strength.

### Typical Mechanical Properties:

Yield Strength (Mpa)	Tensile Strength (Mpa)	Elongation (%)	Impact Value (J)
min. 470	min. 550	min. 17	180 (-30°C)

### Packaging:

**GTAW Wire** (Ø in mm): 2.00 MM / 2.40 MM in 5.00 Kg Packing

### Welding Parameters:

Wire Diameter	Shielding Gas	Current (A)		Voltage (V)	
		Min.	Max.	Min.	Max.
2.00 mm	Ar	90	180	12	18
2.40 mm		100	200	13	20



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