

Weldcote Metals

Alloy ER80S-D2

AWS A5.28



Description and Applications:

Copper coated for GMAW and TIG welding in boiler pressure vessel, pipework and crane construction as well as in structural steel engineering. High quality, very tough deposit of high crack resistance and non-aging. Recommended for service in temperature range -45°C (TIG) or -40°C (GMAW) to +550°C. Good copper bonding with low total copper content. Very good welding and flow characteristics. Preheating interpass and postweld heat treatment as required by base metal.

Chemical Composition of ER80S-D2

C	Mn	Si	Mo
0.10	1.80	0.65	0.50

Single values are maximum unless otherwise specified.

Mechanical Properties

Tensile Strength	PSI: 79,800-98,600
	MPA: 550-680
Yield Strength (min)	PSI: 68,200
	MPA: 470
Elongation % (min)	22

Weldcote Metals believes this data to be accurate and to reflect qualified expert opinion regarding current research. However, Weldcote Metals can not make any expressed or implied warranty as to this information.