

PRODUCT DATA SHEET

MIG/TIG D2



MIG/TIG D2 is a low alloy solid wire, with Mn and Mo additions, designed for welding low alloy steels with high tensile strength. For use in the stress relieved condition. Often used in oil process pipework and fittings where resistance to sulphide-induced stress corrosion cracking is important.

Classifications		
AWS	A5.28	ER 90S-D2/ER 80S-D2 (depending on gas used)
MIG		
EN	14341-A	G 50 5 M G4Mo
EN	14341-B	G57 P 5 M G4 M3I (nearest)
TIG		
EN	636-A	W 50 2 WO
EN	636-B	W 57 P 2 W4M3 (nearest)

Typical Mechanical Properties (All weld metal in the as welded condition)		
	MIG	TIG
Tensile Strength	650 MPa	630 MPa
Yield Strength	560 MPa	520 MPa
% Elongation on 5d	22	26
Charpy V-Notch at +20°C	150 J	200 J
Charpy V-Notch at 0°C	120 J	-
Charpy V-Notch at -20°C	90 J	-

Typical Chemical Analysis			
% Carbon	0,08	% Sulphur	0,01
% Manganese	1,8	% Molybdenum	0,5
% Silicon	0,7	% Copper	0,12
% Phosphorous	0,01		

Packing Data MIG (DC+)				
Diameter (mm)	Current		Pack Mass (kg)	Item Number
	Amps (A)	Volts (V)		
0,8	140	22	15,0	W078207
0,9	180	24	15,0	W078208
1,0	230	25	15,0	W078210
1,2	280	26	15,0	W078212

TIG (DC-)				
Diameter (mm)	Current		Pack Mass (kg)	Item Number
	Amps (A)	Volts (V)		
1,6	100	12	5,0	W078202
2,0	100	12	5,0	W078204
2,4	100	12	5,0	W078206

Suggested gas for welding: Argoshield® 5 (MIG), Argon (TIG)

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