

**Classifications**

EN ISO 16834-A:2007	: G 55 2 C Z	KS D 7025	: YGW21
EN ISO 16834-B:2007	: G 62A 2 U C 3M1T	JIS Z 3312	: G 59J A 1 U C 3M1T
AWS A5.28-05	: ER80S-G		

**Description**

- For butt and fillet welding of machineries, heavy equipments, pressure vessels and steel that demand for creep-resistant in high temperature
- Superior arc stability and X-ray soundness
- Stable weldability on high welding current
- Beautiful weld appearance due to low spatter

**Typical chemical composition of wire (%)**

C	Si	Mn	P	S	Mo	Ti
0.07	0.84	1.95	0.014	0.005	0.31	0.17

**Typical mechanical properties of all-weld metal**

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				-5°C	-20°C	
AWS A5.18		min. 550				
EN ISO 16834-B	min. 530	620~820	min. 15	≥ 47		CO <sub>2</sub>
Example	550	640	27	120	110	CO <sub>2</sub>

**Operating data**

	Dia.(mm)	1.2		1.4	
		120 ~ 350	150 ~ 400	80 ~ 180	100 ~ 250
Current (Amp.)	Flat (PA/1G)	120 ~ 350	150 ~ 400	80 ~ 180	100 ~ 250
	Vertical (PF/3G)	80 ~ 180	100 ~ 250	80 ~ 180	100 ~ 250
	Overhead (PE/4G)	80 ~ 180	100 ~ 250	80 ~ 180	100 ~ 250

**Polarity and Shielding gas**

- DCEP (DC+)
- CO<sub>2</sub> : 100% CO<sub>2</sub> (15~25ℓ /min.)

**Approvals**

Shielding gas	NK
CO <sub>2</sub>	KSW3Y46G

\* Others: JIS