

# ROYAL –ER 80SG (ER 80SG )

AWS –SFA A 5.28 ER 80SG EN ISO 16834 A G/W Z Mn3Ni1Cu

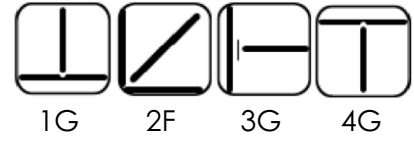
## Applications

In general classification of metal requirements for welding of steel structures, pipe lines, construction of machinery, pressure vessels, where required strength 550 N/mm<sup>2</sup> min.

## Characteristics on Usage

Royal 80SG is a solid wire for flat and horizontal fillet welding position. As the deposition rate very high, gives smooth flow, shiny weld beads of radiographic quality.

## Welding Positions



## Packing

Each Packets content 5 kg of Wire Rods having length 1000 mm.

MIG TIG WIRES

## Typical Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Mo%	Cu %
0.08	1.50	0.20	0.020	0.020	0.50	0.20

## Typical Mechanical Properties Of Weld Metal

U.T.S. (N/mm <sup>2</sup> )	Y.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %	CVN IMPACT AT - 20°C ( J )
635	520	24	45