DURAMAX®
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Product
Data Sheet

STEEL AND LOW ALLOY WELDING WIRE DM80SD-2

Classification: ***ER80S-D2*** ***AWS A5.28 / ASME SFA 5.28***

Application

Type ER80S-D2 filler metal contains a high level of deoxidizers (manganese & silicon) to control porosity when welding with Co2 as the shielding gas, and molybdenum for increased strength.

Product Information

Weld Process	Mig (GMAW) and Tig (GTAW)	Alloy	80S-D2	Alloy	DM80SD-2

AWS Chemical Composition Requirements

C	Mn	Si	P	S	Ni	Mo	Cu	Other
0.07 - 0.12	1.60 - 2.10	0.50 - 0.80	0.025 max	0.025 max	0.15 max	0.40 - 0.60	0.50 max	0.50 max

Deposited Chemical Composition % (Typical)

C	Mn	Si	P	S	Mo	Cu
0.09	1.65	0.58	0.012	0.006	0.55	0.15

Deposited All Weld Metal Properties % As-Welded

Tensile Strength	Yield Strength	Elongation (%)	Hardness	Ferrite WRC (FN)	CVN Impacts	
					@	°F
85,000psi	71,500psi	21%			60 ft. lbs.	+32

Recommended Weld Parameters

Process	Diameter	Volts	Amps	IPM
SHORT ARC	.030	16 - 18	75 - 125	176 - 324
	.035	15 - 18	100 - 160	132 - 228
	.045	17 - 18	160 - 120	149 - 208
SPRAY ARC	.030	26 - 28	200	560
	.035	27 - 29	250	504
	.045	28 - 31	265	336
	.052	29 - 31	300 - 340	280 - 350
	1/16	30 - 36	350 - 400	220 - 280

For additional information please visit our website at Duramax-weld.com or email info@duramax-weld.com

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