TG-S80AM TRUSTARC™

TIG welding rod and wire

Features: ▪ Suitable for 780MPa tensile strength steel

Classification: AWS A5.28 ER110S-G

Shielding gas: Ar

Identification color: -

Polarity: DCEN

Packaging data

	Spool	Tube		
ϕ mm	**kg**	**kg**	**Length mm**	**g/piece**
1.2	10	5	1,000	9
1.6	-	5	1,000	16
2.0	-	5	1,000	25
2.4	-	5	1,000	35
Volume mm	240W, 110H, 230L	40W, 35H, 1015L		

Composition (wire mass%)

	Typical	Guaranty [a]
C	0.07	0.12
Si	0.07	0.20
Mn	1.10	0.90~1.40
P	0.004	0.025
S	0.008	0.025
Ni	2.92	2.60~3.10
Cr	0.36	0.10~0.60
Mo	0.69	0.40~0.90
Cu	0.14	0.50

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	Wire	Rod
1.2	50~280	-
1.6	-	60~220
2.0	-	80~240
2.4	-	100~260

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	760	665min.
TS (MPa)	880	759min.
El on 4d (%)	23	15min.
IV -60℃ (J)	240	27min.

Approvals

ABS	5YQ690A H5, 5YQ690SA H5
LR	5Y69m H5, 5Y69M H5 (Auto)
DNV	ⅤY69M, H5
BV	SA5Y69M H5
NK	KSW5Y69G (I) H5
CCS	5Y69SM H5