HILCO K80

MAG wires – low alloyed steel – high strength

AWS A5.28: ER 110 S-G

EN ISO 16834-A: G 69 4 M Mn3Ni1CrMo

Wire type:
MAG Solid wire

Current:
=+

Welding positions:


Shielding gas:
M21

K80 is our solid wire for MAG welding low alloyed high strength steels having a nominal yield strength of 690 MPa such as: HY 80, N-A-XTRA 63, N-A-XTRA 70, Weldox 700, Grade 100, USS T-1 and similar HSLA steel grades. Typical applications include crane fabrication, automotive and transport industries. A low heat input is recommended to obtain the mechanical properties desired.

Base materials to be welded:

- Fine grain steel S620QL1, S690QL1, S700MC
  N-A-XTRA 63-70, TStE620-TStE690, T1, Weldox 700
- Pipe steel L480-L550, API 5L X65-X80

Applications:

- General fabrication & construction
- Oil & Gas Industry
- Transport & Lifting Industry

Chemical composition, wt.% weld metal – typical:

C	Mn	Si	S	P	Cr	Ni	Mo	Cu	V
0,08	1,50	0,60	≤ 0,025	≤ 0,025	0,35	1,50	0,25	< 0,25	0,09

Mechanical properties, weld metal – typical:

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Impact Values ISO-V J
As welded	≥ 690	≥ 750	≥ 17	-40°C > 47

Packaging and welding data:

Dia. mm.	Spool type	Weight / spool kg.	Current A
1,2	B300	15	120-350