



AWS A5.28 ER80S-G
JIS Z3316 GYT60

Characteristics:

It is designed for welding of high tensile 590N/mm² steel. Commonly used is flat or horizontal fillet welding. It is suitable for root pass welding of pipes and applied in welding Mn-Mo, Mn-Mo-Ni alloy high tensile steel.

Applications:

It is suitable for welding of high strength steel used in steel construction, pressure vessels, vehicles and bridges

Notes on Usage:

1. Electrode Stick Out must be kept between 15-25 mm.
2. Use 100%CO₂ as shielding gas and the flow rate must be controlled that recommended 7-12l/min when arc current is 100-200Amp and goes up to 12-15l/min when arc current rises to 200-300Amp.
3. Proper welding parameter shall be adopted for better welding performance.

Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S	Mo
0.08	1.72	0.67	0.015	0.011	0.33

Typical mechanical properties of weld metal

YP N/mm ²	TS N/mm ²	EL %
540	660	29

Sizes available

Diameter (mm)	2.4
Length(mm)	915
Weight per box(kg)	5