



ED SGA 31

Manufactured by **FLIESS-GERMANY**

MIG wires for High Strength Steel – **AWS A5.28/ASME SFA- A5.28 ER80S-D2**

Key Characteristics

- Wire for welding high strength low alloy steel
- Used Predominantly after stress relieving
- Provides good combination of strength and toughness

Typical Applications

- Welding of High strength steels.
- Crane Manufacturing, mining, pressure vessels

Base Material

Wide range of engineering steels with yield strength up to 540 Mpa (78ksi) and UTS up to 620 Mpa(90ksi)

ASTM a 487 Steel grades 2A/B/C

AISI 4130

Typical Analysis %

Typical Wire Composition	%C 0.07	%Mn 1.7	%Si 0.5	%S 0.010	%P 0.007
Typical Wire Composition	%Cr 0.20	%Ni 1.6	%Mo 0.45	%Cu 0.014	%Ti 0.05

Mechanical Properties

	Y.S. MPa (ksi)	T.S MPa (ksi)	Elongation %	Impact Energy J
Typical Results (all weld metal) As welded	690 mpa	770 mpa	4d/5d 17	-60C 47 J

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Ordering Information

Product Number	Product (AWS Specification)	Dimension mm/inches	Single Tube Weight kg/lb	Box Weight kg/lb
419090115	ED SGA-31 (ER80S-D2)	0.90 mm (0.035")	15.0 kg (33.0 lb)	15.0 kg (33.0 lb)
419120115	ED SGA-31 (ER80S-D2)	1.2 mm (0.045")	15.0 kg (33.0 lb)	15.0 kg (33.0 lb)

