

**ROYAL –ER 80SG (ER 80SG )**

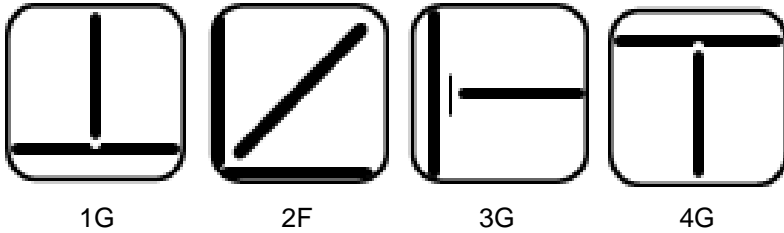
AWS –SFA A 5.18 ER 80SG

**Applications**

In general classification of metal requirements for welding of steel structures, pipe lines, construction of machinery, pressure vessels, where required strength 550 N/mm<sup>2</sup> min.

**Characteristics on Usage**

Royal 80SG is a solid wire for flat and horizontal fillet welding position. As the deposition rate very high, gives smooth flow, shiny weld beads of radiographic quality.

**Welding Positions****Chemical Composition Of Weld Metal**

C%	Mn%	Si%	S%	P%	Mo %	Cu %
0.08	1.35	0.50	0.020	0.020	0.30	0.35

**Mechanical Properties Of Weld Metal**

U.T.S. (N/mm <sup>2</sup> )	Y.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %	CVN IMPACT AT - 20°C ( J )
550	460	22	30

**Packing**

Each Packets content 5 kg of Wire Rods having length 1000 mm.