

Supershield EG-82T

Type : Self-Shielded

Conformances

AWS A5.26/ ASME SFA5.26 EG82T-G

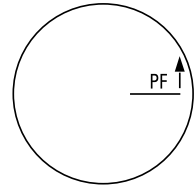
Applications

- Storage tank
- Pressure vessels

Features

- Electro gas arc welding (EGW)
- Vertical- up, V-groove & Square Butt joint single pass EGW process
- Good impact value at low-temperature

Welding Position



Current

DC +

Shielding Gas

No shielding gas

Diameter / Packaging

Diameter	Coil
mm (in)	25kg (55lbs)
2.4 (3/32)	√

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Mo	Ni
0.05	0.37	1.50	0.005	0.003	0.35	1.22

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft-lbs)
539 (78,200)	681 (98,800)	24	-40 (-40)	50 (37)

Typical Welding Parameters

Diameter, Polarity Shielding Gas	CTWD mm (in)	Wire Feed Speed m/min (in/min)	Amp. (A)	Volt. (V)	Deposition Rate kg/hr (lb/hr)
2.4mm (3/32 in) DC+					
No shielding gas	38 (1.49)	6.4 (250)	380-450	34	10 (22.0)
		7.6 (300)	450-480	36	12 (26.5)
		8.9 (350)	480-550	38	15 (33.1)
		10.2 (400)	550-600	45	18 (39.7)

SMW

SAW

GMW

GTAW

FCW

Non-FERROUS

APPENDIX