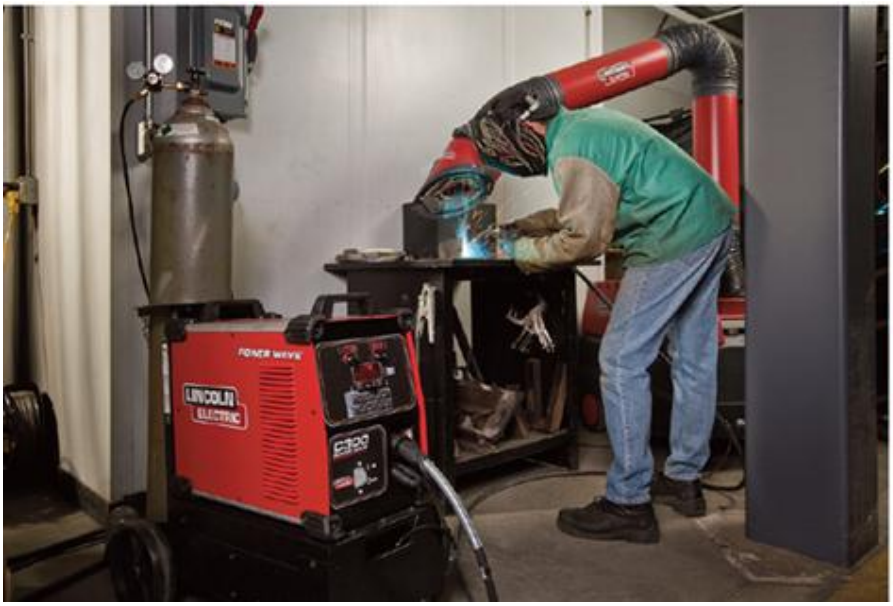
MERIT LMC-8 ™

AWS ER80S-G



Merit™ LMC8 is a copper coated MIG wire that is an excellent choice for single and multi-pass welding on carbon and low-alloy steels. Shielding gases include argon/oxygen blends.

KEY FEATURES

- Excellent drawing and copper coating techniques ensure good Feedability.
- Will support all the traditional modes of GMAW metal transfer: short-circuiting, and pulsed spray.
- Precision layer wound spools are well suited for applications where accurate and consistent wire feeding is necessary.
- Excellent bead profile.

APPLICATIONS

- Pressure vessel forging and valves

WELDING POSITIONS

All

CONFORMANCE

AWS SFA 5.28, ASME Section-II Part-C SFA 5.28

Dia, mm	Coil, Kg	Drum, Kg	Product no
1.2	15		ICMO8120
1.2		100	ICMO8121
1.2		250	ICMO81225

WIRE COMPOSITION (1) – As required per AWS SFA 5.28, ASME Section-II Part-C SFA 5.28

CHEMICAL COMPOSITION, ELECTRODE						
	% C	% Mn	% Si	% S	% P	% Cu (Total)
Requirements - AWS ER80S-G	0.07-0.12	1.60-2.10	0.50-0.80	0.025 max	0.025 max	0.50 max
(2) Typical results	0.07-0.12	1.60-2.10	0.50-0.80	0.025 max	0.025 max	0.10 max

	% Mo	%Ni
Requirements - AWS ER80S-G	0.40-0.60	0.15 max
(2) Typical results	0.40-0.60	0.15 max

MECHANICAL PROPERTIES OF ALL WELD METAL				
	Tensile strength MPa	Yield Strength MPa	Elongation (%)	Charpy V-Notch,J (ft.lbf) @-5°C
Requirements - AWS ER80S-G	560 min	Not Specified	Not Specified	Not Specified
[(2)] Typical results- As welded 80:20 % Ar:CO_2	643	596	23	191

(1) Single values are maximums.

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application.

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Subject to Change – This information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.com for any updated information.

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