

SG Ni2,5

CATEGORY GMAW-GTAW Solid wires

TYPE Solid welding wire for extra low temperature applications.

APPLICATIONS Filler metal developed for fine grain steels and cold-tough steels. Typical applications are welding boilers for liquid petrol gas (LPG)

PROPERTIES A copper coated, Ni-alloyed (2,4% Ni), solid wire for low temperature steels in applications such as vessels, pipes and in the offshore industry with a minimum yield strength of 470 Mpa. The wire provides excellent impact toughness down to -60°C.

CLASSIFICATION

AWS	A 5.28: ER 80S-Ni2
EN ISO	14341-A: G 50 8 M ZG3Ni2
DIN	8575:

SUITABLE FOR S275N, S420N, S275NL, S420NL, P275NL2-P355NL2, 12Ni14G1, X12Ni5, 11MnNi5-3, 13MnNi6-3

APPROVALS CE approved

WELDING POSITIONS:



TYPICAL ALL WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Mo	P	S
0,1	1.1	0,6	-	2.4	-	<0.015	<0.015

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
				-20°C	-40°C	-60°C	
AW	540	630	28		100	60	

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A) DC+	spool / drum / type	kg / spool / drum	kg / pallet
0,8	16-22	40-170	K-300 / Drum	15 / 250	1080 / 1000
1.0	18-28	80-280	K-300 / Drum	15 / 250	1080 / 1000
1.2	20-33	120-350	K-300 / Drum	15 / 250	1080 / 1000

REDRYING TEMPERATURE not required

GAS ACC. EN ISO 14175: M21