

<b>CATEGORY</b>	GTAW Solid wires	
<b>TYPE</b>	Filler metal for fine grain steels and cold-tough steels.	
<b>APPLICATIONS</b>	Offshore requirements at working temperatures down to -60° C such as crane, vessel, rigs, platforms, pipelines for NACE requirements, boiler, tubing etc.	
<b>PROPERTIES</b>	Excellent impact properties at low temperatures due to the addition of Nickel and increased yield strength above 460 MPa.	
<b>CLASSIFICATION</b>	AWS	A 5.28: ER 80S-Ni1
	EN ISO	636-A: W 46 6 3Ni
	F-nr	6
	FM	1

SUITABLE FOR	Materials	DIN	EN	ASTM
	shipbuilding	A, B, D, E, AH 32 - EH 36	same	Typical
	Unalloyed steels	St 33, St 37-2 - St 52-3	S185 - S355-S460	A 258 / A 516
	boiler steels	H I, H III, 17Mn4, 19Mn5	P235GH, P355GH	A 662 / A 387
	pipe steels	St 35.8, St 45.8	P235T1/T2, P460NL2	A 738 / A 612
	-	StE 210.7 TM, StE 480.7 TM	L210 - L480MB	A 299
	Fine grain steels	StE 255 to StE 460	S255 - S500 (NL1,2)	-
	API-standard	X 42, X65	X 42, X65	-

<b>APPROVALS</b>	CE
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**TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)**

C	Si	Mn	P	S	Ni
0.08	0.5	1.05	0.007	0.015	0.9

**ALL WELD MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0.2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)	Impact Energy (J) ISO-V	
				-40°C	-60°C
As Welded /	500	570	24	70	55

**WELDING PARAMETERS / PACKING**

D (MM)	WELDING PARAMETERS	WELDING PARAMETERS	PACKING	PACKING
		CURRENT (A) DC-	SINGLE	MASTER
1,6 X 1000 MM		50-90	5 KG CARTONS	25 KG CARTONS
2,0 X 1000 MM		70-110	5 KG CARTONS	25 KG CARTONS
2,4 X 1000 MM		110-180	5 KG CARTONS	25 KG CARTONS
3,2 X 1000 MM		150-250	5 KG CARTONS	25 KG CARTONS

<b>REDRYING TEMPERATURE</b>	Not required
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<b>GAS ACCORDING EN 14175</b>	I1
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