

CATEGORY	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	636-A: W 42 9 2Ni2
	F-nr	6
	FM	1

SUITABLE FOR	For cryogenic construction steels and Ni bearing low temperature steels. 11MnNi5-3, 13MnNi6-3, 15NiMn6, S275NL-S460NL, S275ML-S460ML, P275NL2-P460NL2, P355ML2-P460ML2 ASTM: A203 grade A/B, A333/A334 grades 1/6/7, A350 grade LF2/LF5/LF6, A352 grade LC1/LC2
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APPROVALS	CE
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WELDING POSITIONS:



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	Ni
0.1	0.5	1.05	2.45

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V		
				-40°C	-60°C	-80°C
As Welded /	540	630	28	100	60	47

WELDING PARAMETERS / PACKING

D (MM)	WELDING PARAMETERS	WELDING PARAMETERS	PACKING	PACKING
		CURRENT DC- (A)	SINGLE	MASTER
1.6 X 1000		50-90	5 KG CARTONS	25 KG CARTONS
2.4 X 1000		110-180	5 KG CARTONS	25 KG CARTONS
3.2 X 1000		150-250	5 KG CARTONS	25 KG CARTONS

REDRYING TEMPERATURE	Not required
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GAS ACCORDING EN 14175	I1
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