



TIGIL 80S-Ni1

GTAW LOW ALLOY STEEL (Low Temperature)

AWS A/SFA 5.28 **ER80S-Ni1**

CLASSIFICATION:

EN ISO 636-A
W 55A 5U N2

KEY FEATURES:

- Copper coated low alloy steel solid filler wire & rod
- Typical 1%Ni-Mn alloy
- Uniform copper coating
- Medium strength weld deposit gives high impact at -45°C
- Radiographic quality weld

APPROVALS: ABS/BV/CE

TYPICAL APPLICATIONS:

- Welding of 1% Ni steels
- Welding fine grained and low alloyed Ni steels
- Welding of steels for application at sub-zero temperature


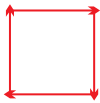
TYPICAL CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt %:

C	Mn	Si	Ni
0.065	1.0	0.5	0.9

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -45°C, J
Typical	As Welded	565	490	27	55

PARAMETERS - PACKING DATA:

Ø x L, mm	Net Wt., Kg		
1.6 x 1000	20	 DCEN	All Positions 
2.0 x 1000	20		
2.4 x 1000	20		
		STORAGE / HANDLING : Keep dry and follow handling instructions mentioned on the box	

Shielding Gas	Gas Flow Rate, LPM
Ar	10-15

Available in Standard carton packing of 20 kg box, containing 4 plastic tubes of 5 kg each.