

GETIG 80S-Ni3

IDENTIFICATION

Getig 80SNi3, ER 80SNi3

CLASSIFICATION

AWS/SFA 5.28: ER80S-Ni 3

DESCRIPTION

TIG filler wire containing about 3.5 percent Nickel is recommended for root run as well as for joint filling. The weld metal gives high impact values at subzero temperature up to minus 80°C. Deposited weld metal is of x-ray quality.

CHEMICAL ANALYSIS (RANGE) %

C	Mn	Si	Cu	S	P	Ni
0.06 - 0.12	0.8 - 1.25	0.40 - 0.80	0.35 max	0.025 max	0.025 max	3.0 - 3.75

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	YS (MPa)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
550 - 650	470 - 580	24 - 30	-80°C	30 - 90

TYPICAL APPLICATIONS

C-Mn steels where good toughness is required at minus 80°C.

- For welding 3.5 percent nickel steel.
- A 350 Grade LF2, LF5, APL 5LX Grade 65
- General and off-shore engineering, structural and weathering steels, pipe work and pressure vessels.

SHIELDING GAS : Pure Argon

PACKING PARAMETERS

Size (mm)	Length (mm)	Packing / Pkt (kg)	Packing / Box (kg)
1.6	1000	5	5 x 4 = 20
2	1000	5	5 x 4 = 20
2.40 / 2.50	1000	5	5 x 4 = 20
3.15 / 3.20	1000	5	5 x 4 = 20