GWELD
SEAL OF TRUST

GETIG 80SNi2

IDENTIFICATION
Getig 80SNi2, ER 80SNi2

CLASSIFICATION
AWS/SFA 5.28: ER 80SNi2

DESCRIPTION
TIG filler wire containing about 1.0 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 60°C. Deposited weld metal is of x-ray quality.Recommended single as well as multi-pass welding.

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	2.0 - 2.75

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	YS (MPa)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
570 min	480 min	24 - 30	-50°C	40 - 120
			-60°C	30 - 100

TYPICAL APPLICATIONS
C-Mn steels where good toughness is required at minus 50°C.
- ASTM A 333, A 334 Grade 6
- 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 : CO2 or 80% Argon + 20% CO2

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