

GM 80S-Ni1

IDENTIFICATION

GM 80SNi1, ER 80SNi1K

CLASSIFICATION

AWS/SFA 5.28: ER80S-Ni1K

DESCRIPTION

Mig 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	Mo	S	P	Ni	Cr	V
0.12 max	1.25 max	0.40 - 0.8	0.35 max	0.35 max	0.025 max	0.025 max	0.80 - 1.1	0.15 max	0.05 max

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	PS (MPa)	EL (%) (L=4D)	CVN Impact Value	
550 min	470 min	24 - 30	Temp	Joules
			-50°C	30 min

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

WELDING CURRENT : DC (-)

PACKING PARAMETERS

Size (mm)	Weight / Spool (kg)
0.8	15
1	15
1.2	15
1.6	15