



TIGFIL 80S-Ni2

GTAW LOW ALLOY STEEL (Low Temperature)

AWS A/SFA 5.28 ER80S-Ni2

CLASSIFICATION:

EN ISO 636-A
W 55P 5U N5

KEY FEATURES:

- Copper coated low alloy steel solid filler wire & rod
- Typical 2.5% Ni-Mn alloy
- Uniform copper coating
- Tough, crack resistant weld deposit gives high impact at -60°C
- Radiographic quality weld

APPROVALS: CE/ABS/BV

TYPICAL APPLICATIONS:

- Welding of 2.5% Ni steels
- Welding fine grained and low alloyed Ni steels
- Welding of storage tanks for low temperature application
- Offshore applications



TYPICAL CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt %:

C	Mn	Si	Ni
0.06	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 -60°C, J
Typical	PWHT: 600°C for 1 hr	590	510	28	50

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.