

PRODUCT DATA SHEET

MIG/TIG 80 NiI



MIG/TIG 80 NiI is designed for welding low alloy steels with 1% Ni and fine grain steels as well as for low temperature applications that require good sub-zero toughness.

Classifications		
AWS	A5.28	ER 80S-NiI
MIG		
EN	I4341-A	G 46 4 M G3 Ni I
EN	I4341-B	G49 A 4 GN 2 (nearest)
TIG		
EN	636-A	W 50 4 W 3Ni I
EN	636-B	W 57 A 4 WN2 (nearest)

Typical Chemical Analysis			
% Carbon	0,1	% Sulphur	0,01
% Manganese	1,1	% Nickel	1,0
% Silicon	0,6	% Molybdenum	0,1
% Phosphorous	0,01	% Copper	0,12

Typical Mechanical Properties (All weld metal in the as welded condition)		
	MIG	TIG
Tensile Strength	600 MPa	600 MPa
Yield Strength	530 MPa	500 MPa
% Elongation on 5d	26	26
Charpy V-Notch at -20°C	130 J	130 J
Charpy V-Notch at -40°C	80 J	80 J

Packing Data MIG (DC+)				
Diameter (mm)	Current		Pack Mass (kg)	Item Number
	Amps (A)	Volts (V)		
1,0	230	25	15,0	W078224
1,2	280	26	15,0	W078226

TIG (DC-)				
Diameter (mm)	Current		Pack Mass (kg)	Item Number
	Amps (A)	Volts (V)		
1,6	120	14	5,0	W078228
2,0	120	14	5,0	W078230
2,4	120	14	5,0	W078232

Suggested shielding gas: Argoshield® 5 (MIG), Argon (TIG)

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