

# PRODUCT DATA SHEET

## TIG 80Ni2



TIG 80Ni2 is designed for welding low alloy steels with 2% Ni and fine grain steels as well as for low temperature applications that require good sub-zero toughness.

### Classifications

AWS	A5.28	ER 80S-Ni2
EN	636-A	W 50 6 W2Ni2
EN	636-B	W 57 A 6 WN5 (nearest)

### Typical Chemical Analysis

% Carbon	0,1	% Sulphur	0,01
% Manganese	1,0	% Nickel	2,3
% Silicon	0,55	% Copper	0,12
% Phosphorous	0,01		

### Typical Mechanical Properties (All weld metal in the as welded condition)

Tensile Strength	620 MPa
Yield Strength	530 MPa
% Elongation on 5d	26
Charpy V-Notch at -20°C	130 J
Charpy V-Notch at -40°C	80 J
Charpy V-Notch at -60°C	50 J

### Packing Data

Diameter (mm)	Pack Mass (kg)	Item Number
1,6	5,0	W078234
2,0	5,0	W078236
2,4	5,0	W078238

Suggested gas for welding: Argon

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