

❖ Product Description

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| I. Copper coated low alloy solid wire | IV. Tough, crack resistant and weld deposit gives high impact at -60°C |
| II. Uniform copper coating | V. Radiographic weld quality |
| III. Typical 2.5% Ni-Mn alloy | |

❖ Range of Application

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|---|---|
| I. For welding 2.5%Ni steels | III. For welding storage tanks used for low temperature application |
| II. Also for welding fine grained and low alloy Ni steels | IV. Suitable for off shore applications |

❖ Classification

- AWS/SFA 5.28 ER80S- Ni2

❖ % Chemical Composition

Type of Wire		C	Mn	S	Si	P	Ni	Cu	Other Elements
ER80S- Ni2	Min	-	-	-	0.40	-	2.00	-	-
	Max	0.12	1.25	0.025	0.80	0.025	2.75	0.35	0.50

❖ Mechanical Properties of all weld metal

Condition	UTS, MPa (Min)	YS, MPa (Min)	% Elongation	Charpy "v" Notch Impact @-60°C
PWHT	550	470	24	27J

❖ Wire Size & Welding Position

- Diameter in mm- 0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60
- Weld Position- All position

❖ Current & Gas Flow

- DCEP; 15-22lit/min

❖ Packaging

Sizes Available in mm	0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60								
Packing Code	A	B	C	D	E	F	G	H	I
Packing Available	SD 100	SD200	SD270	SD 270	SD300	SD300	100kg Drum Pack	250kg Drum Pack	350kg Drum Pack
Net Weight of Wire	1KG	2KG	12.5KG	15KG	12.5KG	15KG	100KG	250KG	350KG

Special Notes: -

- (1) All the value above mentioned are typical values.
- (2) Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding.

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