

❖ Product Description

- | | |
|---|---|
| I. Low alloy steel wire copper coated with 1% or min addition of Ni | IV. Radiographic weld quality |
| II. The weld deposit has excellent tensile strength as much as 560MPa | V. Gives high impact at -45°C for medium quality welds. |
| III. Capable of producing high toughness with max 1%Ni | VI. Uniform copper coating |

❖ Range of Application

- | | |
|---|---|
| I. Suitable for welding of steels containing 1% Ni | III. Excellent for welding low alloy, finely grained Ni steel |
| II. For welding steel structure for application at sub-zero temperature | |

❖ Classification

- AWS/SFA 5.28 ER80SNi-1

❖ Chemical Composition

Type of Wire		C	Mn	Si	S	P	Cu	Ni	Cr	Mo	V	Other Elements total
ER80SNi-1	Min	-	-	0.60	-	-	-	0.80	-	-	-	-
	Max	0.12	1.25	0.80	0.025	0.025	0.35	1.10	0.15	0.35	0.05	0.50

❖ Mechanical Properties of all weld metal

Condition	UTS, Mpa (Min)	YS, Mpa (Min)	% Elongation	Charpy "v" Notch Impact @ -45°C
As Welded	550	470	24	27J

❖ Wire Size and Weld Position

- Diameter in mm-1.6, 2.0 2.40,3.20,4.00 and 5.00.
- All position

❖ Current and Gas- Flow Rate

- DCEN & 8-15 lit/min

❖ Packaging

Sizes available in cut length of 1000mm	1.60,2.00,2.40,3.20,4.00,5.00			
Packing Code	A		B	
Packing Available	5kg PLASTIC TUBE	20KG BOX	10KG PAPER TUBE	20KG BOX
Net Weight of Wire	5	20	10	20

Special Note: -

All the value above mentioned are typical values.

- (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.

SHAKUNT ENTERPRISES PRIVATE LIMITED

Corporate Office: - 619/A, EMMAR DIGITAL GREEN, 6th Floor, Sector-61, GURUGRAM (HARYANA)-122102
E-Mail:- info@shakunt.com

Ludhiana Works:- B-XXIX-595/5,Campa Cola Road,Dhandari Kalan Industrial Area-C,Ludhiana (PUNJAB) [INDIA](#)

Dharwad Works:- Plot no.577 C & D,Belur Industrial Area,Dharwad-580011 (KARNATAKA) [INDIA](#)

Vadodara Works:- 67-A,G.I.D.C,Majusar,Savli,Vadodara-397115 (GUJARAT) [INDIA](#)