

## ❖ Product Description

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|---|---|
| I. Low alloy steel wire copper coated with 2.5% 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 -60°C for medium quality welds. |
| III. Capable of producing high toughness with max 2.5%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 steels                  |
| II. For welding steel structure for application at sub-zero temperature | IV. Excellent for welding of storage tanks made for low temperature application |

## ❖ Classification

- AWS/SFA 5.28 ER80SNi-2

## ❖ Chemical Composition

Type of Wire		C	Mn	Si	S	P	Cu	Ni	Other Elements Total
ER80SNi-2	Min	-	-	0.60	-	-	-	2.00	-
	Max	0.12	1.25	0.80	0.025	0.025	0.35	2.75	0.50

## ❖ Mechanical Properties of all weld metal

Condition	UTS, Mpa (Min)	YS, Mpa (Min)	% Elongation	Charphy "v" Notch Impact @ -60°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.

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(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](mailto: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