

## ❖ Product Description

- |  |   |
|--|---|
| <ul style="list-style-type: none"> <li>I. Low alloy steel wire copper coated with 3.5% or min addition of Ni</li> <li>II. The weld deposit has excellent tensile strength as much as 560MPa</li> <li>III. Capable of producing high toughness with max 2.5%Ni</li> </ul> | <ul style="list-style-type: none"> <li>IV. Radiographic weld quality</li> <li>V. Gives high impact at -100°C for medium quality welds.</li> <li>VI. Uniform copper coating</li> </ul> |
|--|---|

## ❖ Range of Application

- |   |   |
|---|---|
| <ul style="list-style-type: none"> <li>I. Excellent usage in petrochemical industry in construction of cryogenic plant and associated pipework</li> <li>II. In the manufacturing and storage of volatile liquids and liquefied gases operating at low temperatures</li> </ul> | <ul style="list-style-type: none"> <li>III. Excellent for welding low alloy, finely grained Ni steels</li> <li>IV. Excellent for welding of storage tanks made for low temperature application</li> </ul> |
|---|---|

## ❖ Classification:

- AWS/SFA 5.28 ER80SNI-3

## ❖ Chemical Composition

Type of Wire		C	Mn	Si	S	P	Cu	Ni	Other Elements Total
ER80SNI-3	Min	-	-	0.40	-	-	-	3.00	-
	Max	0.12	1.25	0.80	0.025	0.025	0.35	3.75	0.50

## ❖ Mechanical Properties of all weld metal

Condition	UTS, Mpa (Min)	YS, Mpa (Min)	% Elongation	Charphy "v" Notch Impact @ -75°C
As Welded	550	470	24	27J

## ❖ Wire Size & 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](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