



AUTOMIG 80S-Ni1

GMAW LOW ALLOY STEEL (Low Temperature)

AWS A/SFA 5.28 ER80S-Ni1

CLASSIFICATION:

EN ISO 14341-B
G 55A 5U M13 N2

KEY FEATURES:

- Copper coated low alloy steel solid filler wire & rod
- Typical 1%Ni-Mn alloy
- Uniform copper coating
- Medium strength weld deposit gives high impact at -45°C
- Radiographic quality weld

APPROVALS: CE

TYPICAL APPLICATIONS:

- Welding of 1% Ni steels
- Welding fine grained and low alloyed Ni steels
- Welding of steels for application at sub-zero temperature



TYPICAL CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt %:

| C | Mn | Si | Ni |
|-------|-----|-----|-----|
| 0.065 | 1.0 | 0.5 | 0.9 |

MECHANICAL PROPERTIES OF ALL WELD METAL:

| | Condition | UTS, MPa | YS at 0.2% offset, MPa | EL% | CVN Impact at -45°C, J |
|---------|-----------|----------|------------------------|-----|------------------------|
| Typical | As Welded | 565 | 490 | 27 | 55 |

PARAMETERS - PACKING DATA:

| | | | |
|----------------------------|-----------------------------|---|---|
| Ø, mm 1.2 1.6 | Kg/Spool 15 15 |  DCEP | All Positions  |
| | | STORAGE / HANDLING : Keep dry and follow handling instructions mentioned on the box | |

| | |
|----------------------|---------------------------|
| Shielding Gas | Gas Flow Rate, LPM |
| Ar/1-5O ₂ | 15-22 |