



AUTOMIG 80S-Ni2

GMAW LOW ALLOY STEEL (Low Temperature)

AWS A/SFA 5.28 ER80S-Ni2

CLASSIFICATION:

EN ISO 636-A
G 55P 6U M13 N5

KEY FEATURES:

- Copper coated low alloy steel solid filler wire & rod
- Typical 2.5% Ni-Mn alloy
- Uniform copper coating
- Tough, crack resistant weld deposit gives high impact at -60°C
- Radiographic quality weld

APPROVALS: CE

TYPICAL APPLICATIONS:

- Welding of 2.5% Ni steels
- Welding of storage tanks for low temperature application
- Welding fine grained and low alloyed Ni steels
- Offshore applications



TYPICAL CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt %:

C	Mn	Si	Ni
0.06	1.0	0.5	2.3

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -60°C, J
Typical	As Welded	590	510	28	50

PARAMETERS - PACKING DATA:

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

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