

NST TIG ER80S-Ni1

AWS A5-28: ER80S-Ni1

EN ISO 636-A: W 46 6 W3Ni1



Low alloyed Tig rod for welding in low temperature applications.

General description:

NST TIG ER80S Ni1 is a copper coated solid wire rod for TIG welding.

Typical usage is within offshore and Oil & Gas pipe welding with low temperature requirements.

Max. Ni content is 1,0%

Can be used for applications where service temperature is down to -60 °C.

Welding positions:



Welding current:

DC-

Gas flow:

10-15 l/min.

Typical chemical composition of welding wire:

C	Si	Mn	P	S	Cr	Mo	Ni	Cu	V
0,09	0,67	1,08	0,006	0,014	0,01	0,00	0,87	0,015	0,002

Type of gas:

Argon

Mechanical properties of all-weld-metal:

Yield and Tensile Strengths			Charpy Impact Test
Yield Mpa	Tensile Mpa	Elongation %	Charpy V (J) -60 °C
>470	550 - 680	≥24	≥ 47

Guidance - Ampere (DC-):

Wire diameter	1,6	2,0	2,4

Packaging information:

1,6mm x 1000mm x 3,0 kg
2,0mm x 1000mm x 3,0 kg
2,4mm x 1000mm x 3,0 kg

Approvals:

CE

Reference / date:

NST TIG ER80S-Ni1
English, 28.10.2019.