

TIGFIL 80S-Ni1

Classification

AWSA/SFA 5. 28 : ER80S-Ni1

Identification: AWS classification embossed at one end of the wire.

Characteristics

A copper coated low alloy GTAW filler/rod with 1.0% Ni. It results in smooth flow, stable arc and minimum spatter under optimum welding conditions. Gives radiographic quality welds. Recommended with arc shielding. The higher content of deoxidizers makes this wire suitable for application where dirt, rust or mill-scale is present.

Typical Applications

For welding of 1% Ni steels through GTAW process. For welding of steels for application of sub-zero temperatures upto -45°C.

Wire Chemistry, wt % (Typical)

C	Mn	Si	S	P	Ni
0.12 max	1.25 max	0.40-0.80	0.025 max	0.025 max	0.80-1.10

Properties of weld metal with 100% Argon gas shielding **Current Condition: DC (-)**

All Weld Mechanical Properties As welded condition

UTS MPa	550 min	CVN Impact value J
Yield strength MPa	480 min	at - 45°C
Elongation % (L=4xd)	25 min	28 Min
Hardness (BHN)	200 max	

The chemistry & mechanical properties of the weld metal will vary with the type of shielding gas used.

Packing Data

Dia (mm)	1.6	2.0	2.5
Length (mm)	1000	1000	1000
Primary Tube (Kg)	5	5	5
No. of Tubes	4	4	4
Secondary Cartons (Kg)	20	20	20

TIGFIL Wires are sealed in polyethylene bags and then packed in primary tubes.

TIGFIL Wires are also available in 5 Kg PSLW spools in 0.8, 1.0 and 1.2 mm sizes for orbital GTAW/TIG welding.



WELDERS TO THE NATION SINCE 1951
ADOR WELDING LIMITED

(Formerly Known as Advani-Oerlikon Ltd.)

www.adorwelding.com

