

TIGFIL 80S-Ni2

Classification

AWSA/SFA 5. 28 : ER80S-Ni2

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

Characteristics

A copper coated low alloy GTAW filler/rod with 2.5% Ni. It results in smooth flow, stable arc and minimum spatter under optimum welding conditions. Gives radiographic quality welds.

Typical Applications

For welding of 2.5% Ni steels through GTAW process. For welding of steels for application of sub-zero temperatures upto -60°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	2.0-2.75

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 - 60°C
Elongation % (L=4xd)	25 min	50 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.



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