NST MIG ER80S Ni1

AWS A5.28: ER80S-Ni1
EN ISO 14341-A: G 46 6 M21 3Ni1

Solid wire for welding of mild and low alloyed steels.

General description:

NST MIG ER 80S Ni1 is a copper coated solid wire for MIG/MAG welding of fine grain structural steels with Argon/CO_2 (M21) mixed shielding gas.

Typical usage is within offshore and Oil & Gas steelworks and pipe welding.

The wire is suitable for welding with a wide range of welding currents with excellent appearance.
It has low spatter performance, and excellent wire feeding capabilities.

Suitable for both manual welding and for robotic / -mechanised welding in all positions, including vertical downwards.

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

Welding positions:

Welding current:

DC+

Gas flow:

12-20 l/min.

Typical chemical composition of welding wire:

C	Si	Mn	P	S	Cr	Mo	Ni	Cu	V
0,10	0,65	1,1	0,008	0,009	0,13	0,03	0,86	0,09	0,002

Type of gas:

Ar/CO_2 mix (M21).

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	

Packaging information:

0.8mm x 15Kg / 250Kg
1.0mm x 15Kg / 250Kg
1.2mm x 15Kg / 250Kg
1.6mm x 15Kg / 250Kg

Approvals:

VdTÜV, CE

Reference / date:

NST MIG ER80S Ni1,
English, 26.04.2017.