

SG Ni2,5 Tig

CATEGORY GMAW-GTAW Solid wires

TYPE Solid welding wire for extra low temperature applications.

APPLICATIONS Filler metal developed for fine grain steels and cold-tough steels. Typical applications are welding boilers for liquid petrol gas (LPG)

PROPERTIES A copper coated, Ni-alloyed (2,4% Ni), solid wire for low temperature steels in applications such as vessels, pipes and in the offshore industry with a minimum yield strength of 470 Mpa. The wire provides excellent impact toughness down to -60°C.

CLASSIFICATION

AWS	A 5.28: ER 80S-Ni2
EN ISO	636-A: W2Ni2 / W 46 8 W2Ni2
DIN	8575:

SUITABLE FOR S275N, S420N, S275NL, S420NL, P275NL2-P355NL2, 12Ni14G1, X12Ni5, 11MnNi5-3, 13MnNi6-3, ASME SA 203 Gr A & B, ASME SA 572 Gr 65

APPROVALS CE approved

WELDING POSITIONS:



TYPICAL ALL WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Mo	P	S
0,1	1.1	0,6	-	2.4	-	<0.015	<0.015

MECHANICAL PROPERTIES

Heat Treatment	Rp0,2 (N/mm ²)	Rm (N/mm ²)	A5 (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				-20°C	-40°C	-60°C	
AW	540	630	28		100	60	

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters		Packing	
D (mm)	Current DC- (A)	single	master
1.6 x 1000	50-90	5 kg cartons	25 kg cartons
2.4 x 1000	110-180	5 kg cartons	25 kg cartons
3.2 x 1000	150-250	5 kg cartons	25 kg cartons

REDRYING TEMPERATURE not required

GAS ACC. EN ISO 14175: I1