

SG Ni3,5 Tig

CATEGORY	GMAW-GTAW Solid wires	
TYPE	Solid Tig welding wire for extra low temperature applications.	
APPLICATIONS	Used in petrochemical industry where it finds applications in construction of cryogenic plant and associated pipework, in the manufacture, storage and distribution of volatile liquids and liquefied gases.	
PROPERTIES	Excelent impact properties at subzero temperatures down to -80°C.	
CLASSIFICATION	AWS	A 5.28: ER 80S-Ni3 UNS: K31240
	EN ISO	636-B: W 57P7 WN71
	DIN	8575:
SUITABLE FOR	ASTM	A 203 Gr D, E, F - A 333 Gr 3 - A 350 Gr LF3 - A 352 Gr LC3
	EN	(BS 1501 Gr 503 - BS 1503 Gr 503 - BS 1504 Gr 503 LT60)

APPROVALS CE approved

WELDING POSITIONS:



TYPICAL ALL WELD METAL ANALYSIS

C	Mn	Si	Ni	Cu	P	S
0,1	1.1	0,6	3.5	0.12	<0.01	<0.01

MECHANICAL PROPERTIES (TYPICAL)

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				-20°C	-40°C	-60°C	
AW	510	620	28		100	60	
PWHT 620°C	477	568	26			40	

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters		Packing	
D (mm)	Current (A) DC-	single	master
1,6 x 1000 mm	50-90	5 kg cartons	25 kg cartons
2,0 x 1000 mm	70-110	5 kg cartons	25 kg cartons
2,4 x 1000 mm	110-180	5 kg cartons	25 kg cartons
3,2 x 1000 mm	150-250	5 kg cartons	25 kg cartons

REDRYING TEMPERATURE not required

GAS ACC. EN ISO 14175: I1