

SG NiMo1

CATEGORY GMAW-GTAW Solid wires

TYPE Solid welding wire for fine grain steels and cold-tough steels.

APPLICATIONS Offshore drilling equipment, crane building, pipeline, platforms, Vessel etc.

PROPERTIES SG NiMo1 is a 0.9% Ni-alloyed (ER80S-Ni1), copper-coated, solid wire for the GMAW/GTAW of low-temperature, fine-grained steels. The deposit provides good impact toughness down to -50°C and is especially suitable for use in the offshore industry.

CLASSIFICATION

AWS	A 5.28: ER 80S-Ni1
EN ISO	16834-A/B: G 62 5 M Mn3Ni1Mo
DIN	8575:

SUITABLE FOR P355NL 1 - P460NL 1., X70, X80, 4130, 8630

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL WEIGHT %

C	Mn	Si	Cr	Ni	Mo
0.10	1.20	0,75	-	0,9	0.3

MECHANICAL PROPERTIES

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	520-640	640-740	32	150	70	22	

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spooling type	kg / spool	kg / pallet
0,8	16-22	40-170	D-200 / K-300 / Drum	5 / 15 / 250	1000 / 1080 / 1000
1,0	18-28	80-280	D-200 / K-300 / Drum	5 / 15 / 250	1000 / 1080 / 1000
1,2	20-33	120-350	D-200 / K-300 / Drum	5 / 15 / 250	1000 / 1080 / 1000

REDRYING TEMPERATURE not required

TIG WELDING 1000 mm. cut lengths are available on request.