

ES TIG 80S-Ni2

GTAW
ER80S-Ni2

ESWECO
The Art of Welding

Description

ES TIG 80S-Ni2 is 2.4Ni-alloyed (ER80S-Ni2), copper-coated rod for the GTAW of low-temperature, fine-grained steels in applications such as pressure vessels, pipes and the offshore industry, with a minimum yield strength of up to 470 MPa. The wire provides good impact toughness down to -60°C.

Current

DC (-)

Classifications

SFA/AWS A5.28	ER80S-Ni2
EN 1668	W2Ni2

Typical all weld metal composition, %

C	Si	Mn	Ni
0.1	0.6	1.1	2.4

Typical mech. Properties all weld metal

Yield stress, MPa	540
Tensile strength, MPa	630
Elongation, %	30

Charpy V

Test temps, °C	Impact values, J
-20	200
-40	180
-60	150

Welding parameters

Diameter, mm	Length, mm	Weight of rods/box, kg
1.0	1000	5.0
1.6	1000	5.0
2.0	1000	5.0
2.4	1000	5.0
3.2	1000	5.0
4.0	1000	5.0