

ES MIG 80S-Ni1

GMAW
ER80S-Ni1

ESWECO
The Art of Welding

Description

ES MIG 80S-Ni1 is a 0.9Ni-alloyed (ER80S-Ni1), copper-coated, solid wire for the GMAW of low-temperature, fine-grained steels. The wire provides good impact toughness down to -50°C and is especially suitable for use in the construction of offshore platforms, pressure vessels, and pipelines.

Current

DC+

Classifications

SFA/AWS A5.28 ER80SNI1

Typical all weld metal composition, %

C	Si	Mn	Ni	Mo
0.1	0.6	1.0	0.9	0.3

Typical mech. Properties all weld metal

Yield stress, MPa	480
Tensile strength, MPa	560
Elongation, %	30

Charpy V

Test temps, °C	Impact values, J
+20	150
0	130
-45	70
-60	20

Welding parameters

Diameter, mm	Wire feed, m/min	Welding current, A	Arc voltage, V
0.8	2.0-10.8	40-170	16-22
1.0	2.7-14.7	80-280	18-28
1.2	3.7-12.4	120-350	20-33
1.6	3.1-8.1	225-480	26-38