

CLASSIFICATIONS

EN ISO 14341-A : G3Ni1
 EN ISO 636A : W3Ni1
 AWS A5.28 : ER 80S-Ni1

DESCRIPTION

- Building up of cranes, transport, industrial facilities, equipment in general, pipelines, shipbuilding, etc
- Working temperatures are between of -45°C and +400°C
- Shielding gas: Ar+CO₂ mix gases can be used for MAG
- Shielding gas: Ar gas can be used for TIG

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL)

C: 0.08 | Si: 0.65 | Mn: 1.10 | Ni: 1.0

MECHANICAL PROPERTIES

Yield Strength (MPa)	Tensile Strength (MPa)	Impact Strength (ISO-V/-45°C)	Elongation (L ₀ =5d ₀) (%)
min. 470	min. 550	min. 27 J	min. 24

BASE MATERIALS

- A106; A515; A714; A131; A369; A210; L290; P235 T1 /T2; P275 T1;
- L360; L415; P275T2; P355N; API X-42; X46; X62; X60; P235GH; P355GH;
- A283; A285; A414; A372; A662; S275; S420; A516; A255; A333; A350; A612

WELDING POSITIONS



CURRENT CONDITION

TIG D.C.(-) / MAG D.C.(+)

OPERATING DATA

Product Code	Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
1011100003	1.20	0.047"	15	BS 300
1011100004	2.0 x 1.000	5/64 x 39"	5	Carton Box
1011100005	2.4 x 1.000	3/32 x 39"	5	Carton Box