

CLASSIFICATIONS

EN ISO 14341-A : ~G3Ni 1
 AWS A5.28 : ER80S-G

DESCRIPTION

- Excellent resistance to atmospheric events due to the presence of Cu, Cr, Ni
- Suitable for bridges, cranes, ground moving machines, boilers, building structures, petrochemical sector, fans gas pipes, fume section, etc
- Shielding gas: Ar+CO₂ mix gases can be used
- Depending on the thickness of the main material to be used, a pre-heating application can be applied to the main material before starting the welding.

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL)

C: 0.08 | Si: 0.80 | Mn: 1.30 | Ni: 0.80 | Cu: 0.40 | Cr: 0.20

MECHANICAL PROPERTIES

Yield Strength (MPa)	Tensile Strength (MPa)	Impact Strength		Elongation (L ₀ =5d ₀) (%)
		(ISO-V/-20°C)	(ISO-V/-40°C)	
510	590	110 J	60 J	25

BASE MATERIALS

- S235JRW, S235J2G3, Patinax 37, Alcodur 50, Koralpin 52, S355J2G3Cu, 9CrNiCuP3-2-4, Corten A-B1, Itacor, WTSt37, WTST52.3, S355K2W

WELDING POSITIONS



CURRENT CONDITION

MAG D.C.(+)

OPERATING DATA

Product Code	Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
1011100010	1.20	0.047"	15	BS 300 Spool