

Classifications

AWS A5.28-05	: ER80S-Ni2
EN ISO 636-A : 2008	: W 46 6 W2Ni2
EN ISO 636-B : 2008	: W 55A 5 W2Ni2

Description

- It is designed for welding of 550MPa high tensile steel for low temperature service of below -60°C
- Suited for welding 2%Ni steel and other low temperature for low temperature pressure vessel, tank and pipe.
- Very good weldability in out of position work
- GTAW rod for welding of low temperature equipment and structure

Typical chemical composition of rod (%)

C	Si	Mn	P	S	Ni
0.09	0.52	1.08	0.007	0.005	2.30

Typical mechanical properties of all-weld-metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) -60°C	Remarks
AWS A5.28	min. 470	min. 550	24	27	-
Example	540	650	34	256(@-60°C) 166(@-70°C)	As Weld
Example	580	680	32	261(@-60°C) 221(@-70°C)	PWHT

* PWHT : 620°Cx1Hr

Operating data

Dia.(mm)	Voltage	Ampere
0.9	10~12	50~70
1.2	10~12	70~100
1.6	12~15	100~125
2.4	15~20	125~175
3.2	15~20	175~200

Polarity and Shielding gas

- DCEN (DC-)
- Ar : 100%Ar (15~25ℓ/min)