

Low alloy solid rod

Classification

AWS A5.28 : ER80S-Ni2
EN 1668 : W 46 6 W2Ni2

General description

Solid rod for welding fine grained and low alloyed nickel steels
High impact value at low temperature (-70°C).
Typical offshore applications

Shielding gases (acc. ISO 14175)

I1 Inert gas Ar (100%)

Approvals

TÜV
+

Chemical composition (w%) typical wire / rod

C	Mn	Si	Ni
0.1	1.1	0.6	2.5

Mechanical properties, typical, all weld metal

	Shielding gas	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J)	
						-62°C	-90°C
Typical values	I1	AW	525	610	28	280	170
	I1	SR 580°C/15 h	500	570	30	230	180

Materials to be welded

Steel grades	Code	Type
General structural steel	EN 10025	S355
Pipe material	EN 10208-2	L360, L415, L445
	API 5 LX	X52, X56, X60, X65
Fine grained steel	EN 10113-2	S355, S420
	EN 10113-3	S355, S420
Low temperature steels	EN 10028-4	11 MnNi 5-3, 13 MnNi 6-3, 15 NiMn 6 (12 Ni 14 G 1, G 2)
	EN 10222-3	13 MnNi 6-3, 15 NiMn 6

Packaging and available sizes

Unit type	Diameter (mm)	
	2.0	2.4
2 and 5 kg tube	X	X
Other sizes and packaging on request		

LNT Ni2.5: rev. EN 22

Liability: All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance **Fumes:** Consult information on Welding Safety Sheet, available upon request