

Normalised designation : ISO 14341-A : G 3Ni1 AWS A5.28 : ER80S-Ni2

Properties :

Full copper wire for soft-protected welding of fine-grained and very high elastic limit steels for cryogenic applications up to temperatures of -60°C. Excellent resistance to cracking issues.

Weldable steels: Fine-grained, high-elastic-limited steels.

EN	ASTM
12Ni9 (1.5635)	
14Ni6 (1.5622)	A352 gr. LC2
13MnNi6-3 (1.6217)	
S/P275 - S/P 420	A516 / A255 / A299 / A333 / A350
P235T1/2 - P355N	A369 / A210 / A106
L210 - L485	
S255 - S550	A516/A255/A333/A350/A612/A714

Mechanical properties :

Re = 500 MPa*

Rm = 600 MPa*

A5 = 22 %

KV = 130 J at -20 °C

80 J at -40 °C

50 J at -80 °C

Settings and conditions: MIG - Continuous Current (electrode)

GAZ (ISA 14175)	ø (mm)	Welding parameters	
		Pulsed bow (A)	(V)
M21 (Ar/CO ₂) C1 (100% CO ₂) 12 - 15 L/min	1	150 - 170	25 - 28
	1,2	180 - 250	26 - 28

Packaging: coil 15 kg

Responsibility: The purpose of this document is to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for the applications for which it is intended. We reserve the right to modify the characteristics of its products without notice. Descriptions, illustrations and features are provided as an indication and cannot be the responsibility of our company. Smoke: View information on the Security Data Sheet available on request