TIG F82

Old reference: TIG 80SNi2

Classification

AWS A5.28 : ER80S-Ni2 ISO 636-A : W2Ni2

Description & Applications

Filler metal rod for GTAW welding under shielding gas for fine grain construction steels and nickel alloyed steels. Resistant to low temperature down to -60°C. Good characteristics of cold toughness.

Main applications: For liquid gas distribution pipes, tanks, off shore, and petro-chemistry**.**

Base materials

High strength steels, fine grain construction steels, cold tough:		
EN	Material N°	ASTM
12Ni9	1.5635	
14Ni6	1.5622	A352 gr. LC2
13MnNi6-3 1.6217	1.6217	
S/P275-S/P420		A516 / A255 / A299 / A333 / A350
P235T1/2-P355N		A369 / A210/ A106
L210-L485		
S255 - S550		A516 / A255 / A333 / A350 / A612 / A714

Typical Weld Metal Composition (%)

C	Si	Mn	Ni	Mo	P	S	Fe
0.08	0.6	1.1	2.5	0.05	<0.02	<0.02	Rem.

All Weld Metal Mechanical Properties

$R_{p0,2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)
530	620	26	-20°C 130 -40°C 80 -60°C 50

Weld Current & Instructions

Welding mode	Shielding gas
TIG = -	Ar : 6-12 l/min Back shielding: Nitrogen /H_2 : 3 - 6 l/min

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