T Union GT Ni1

Low Alloyed Steel GTAW Rod/Wire

Classifications

AWS A5.28	EN ISO 636-A	GB/T 39280
ER80S-Ni1	W 46 6 Z3Ni1	W 55A 6 U N2

Characteristics and typical fields of application

- GTAW rod for welding of low temperature equipment and structure.
- Very good weldability in out of position work; Excellent cold toughness at - 60°C.
- Low content trace elements. Suited for welding 1Ni or 16MnDR steel and other low temperature for low temperature pressure vessel, tank and pipe.

Base materials

P235GH,P265GH,P-S460NL,15MnNi 63.

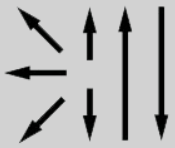
Typical analysis of all-weld metal

C	Si	Mn	P	S	Ni	Cr	Mo	Al	V	Cu
0.10	0.60	1.10	0.008	0.008	0.90	0.03	0.02	⩽0.02	⩽0.03	0.10

Mechanical properties of all-weld metal – typical values (min. values)

Condition	Yield strength $R_{p0,2}$	Tensile strength R_m	Elongation A (L_0=5d_0)	Impact work ISO-V KV J	
	Mpa	Mpa	%	-45°C	-60°C
AW	570(≥470)	660(≥550)	31 (≥24)	210(≥47)	160 (≥27)

Operating data



Polarity:	Dimensions (mm)	Shielding gas:
DC -	1.6X1000 2.0X1000 2.4X1000	(ISO 14175) I1

Approvals

CE,ABS.DNV-GL

All information provided is based upon careful investigation and intensive research.
However, we do not assume any liability for correctness and information is subject to change without notice.