

CLASSIFICATION

EN ISO 16834 : G Mn3Ni1Cu
EN 440: G3 Ni1*
AWS A5.28: ER80S-G

(*) Nearest classification

GENERAL DESCRIPTION

It is a low alloyed GMA welding wire, used for the welding pressure vessels and gas pipes including nickel. It gives a weld metal that has an high mechanical properties against atmospheric environment.

Industry: Petro-chemical industry

CHEMICAL COMPOSITION (W%) TYPICAL, WIRE

C	Si	Mn	Ni	Cr	Cu
0.09	0.60	1.40	0.90	2.40	< 0.40

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Yield Strength : 530 N/mm²
Tensile Strength : 610 N/mm²
Elongation (L=5d) : 26 %
Impact (ISO-V) : 120 J (+20°C)
60 J (-40°C)

SHIELDING GASES (ISO 14175 / EN 439)

MAG : M21 - Ar + 5-25% Co₂
C1 - Co₂ (100%)

Current Type and Polarity : DC (+)

MATERIALS TO BE WELDED

	DIN	EN
Fine Grained Steels	StE 255 - StE 380 TS1E 255 - TS1E 380	S255N ; S420N S255NL - S380NL ; P275NL1 - P355NL1
Weather Resisting Steels	WTSt 37.2 - - - -	S235JRW S355J2G1W, S235J0W, S235J2W S355J01, S355J2W, S355K2G1W Patinax®-F, Patinax®-37 Cor-Ten®-A, Cor-Ten®-B 9CrNiCuP3-2-4
Low Temperature Steels	TTSt35 - -	S225NL 11MnNi5-3 13MnNi6-3

PACKING AND DIAMETER INFORMATIONS

Diameter	0.8	1.0	1.2	1.6	2.0	2.4	3.2	Spool Weight
MIG/MAG Wire	X	X	X	-	-	-	-	15 kg

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.

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