

KC-80SNi2

For 550MPa low temperature service steel(2.0%Ni)

Classifications

AWS A5.28-05	: ER80S-Ni2
EN 14341-A	: G 46 6 M G2Ni2

Description

- It is designed for welding of 550MPa high tensile steel for low temperature service of below -60°C
- suited for welding 2%Ni steel and other low temperature for low temperature pressure vessel, tank and pipe.
- Very good weldability in out of position work

Typical chemical composition of wire (%)

C	Si	Mn	P	S	Ni
0.09	0.52	1.08	0.007	0.005	2.30

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) -60°C	Remarks
AWS A5.28	min. 470	min. 550	24	27	-
Example	624	716	35	45(@-60°C) 41(@-70°C)	PWHT

* PWHT : 620°Cx1Hr

Operating data

Dia.(mm)		1.2	1.4
Current (Amp.)	Flat (PA/1G)	120 ~ 350	150 ~ 400
	Vertical (PF/3G)	80 ~ 180	100 ~ 250
	Overhead (PE/4G)	80 ~ 180	100 ~ 250

Polarity and Shielding gas

- DCEN (DC+)
- Mix : Ar+2%O₂ (15~25ℓ/min)