

Coppered welding wire

Classifications: AWS A5.28-96: ER 80 S-Ni 1
EN 14341-A : G3 Ni 1
EN ISO 636 – A- W3Ni1

Main features :

Low alloy copper coated solid wire designated to weld steel requiring good atmospheric corrosion resistance . Suitable for pipelines and pressure vessels with operating temperatures from -30° to +350° . also for austempering steel. Contains 0.50% molybdenum for strength after stress-relief. be used under protective gases Ar (80) + Co2 (20) or Argon

Chemical analysis %

C	0.08 - 0.10	Ni	1.00
Mn	1.15-1.30	Cr	Max 0.15
Si	0.60 - 0.85	Mo	0.05-0.15
S	MAX 0.025	Cu	Max 0.250
P	MAX 0.025	V	Max 0.050

Material to be weld :

A 487 Gr 2A, 2B, 2C; AISI 4130; A537 Class 2;A106;A515;A131;A369;A210;L290;P235 P1/P2;L360;L415;P355N;API X-42; X46; X62; X60; P235GH; A283; A285; A414; A372; S275; S420;A516;A255;A333;A350;A612

Power

DC +

Gas

Ar / CO₂ - Ar / CO₂ / O₂ - CO₂ (EN 439: M2, C1)

Mechanical Properties

Gas Mix	(Tensile strength) Rm N/mm ²	(Yield strength) Re N/mm ²	(Elongation) A5 (%)	Charpy - 40°C
Ar / CO ₂ (M21)	470	550	26	> 80J

WELDING POSITIONS:

