

# GM 80S-Ni2

## IDENTIFICATION

GM 80SNi2, ER 80SNi2

## CLASSIFICATION

AWS/SFA 5.28: ER80S-Ni2

## DESCRIPTION

Mig wire containing about 1.0 percent Nickel is recommended for root run as well as for joint filling. The weld metal gives high impact values at subzero temperature up to minus 60°C. Deposited weld metal is of x-ray quality. Recommended single as well as multi-pass welding.

## CHEMICAL ANALYSIS (RANGE) %

C	Mn	Si	CU	Mo	S	P	Ni
0.12 max	1.25 max	0.40 - 0.80	0.35 max	0.35 max	0.030 max	0.030 max	2.0 - 2.75

## MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	PS (MPa)	EL (%) (L=4D)	CVN Impact Value	
550 min	470 min	24 - 30	Temp	Joules
			-50°C	50 min

## TYPICAL APPLICATIONS

- C-Mn steels where good toughness is required at minus 50°C.
- For welding DMR 249A steel.
- ASTM A 333, A 334 Grade 6
- A 350 Grade LF2, LF5, APL 5LX Grade 65
- General and off-shore engineering , structural and weathering steels, pipe work and pressure vessels.

**SHIELDING GAS :** CO2 or 80% Argon + 20% CO2

## PACKING PARAMETERS

Size (mm)	Weight / Spool (kg)
1.6	15
2	15
2.40 / 2.50	15
3.15 / 3.20	15