MIDALLOY ER80S-Ni2 WELDING WIRE

CLASSIFICATION

- AWS A5.28 Class ER80S-Ni2 / ASME SFA 5.28 Class ER80S-Ni2 (UNS K21240) and EN10204

DESCRIPTION

- MIDALLOY ER80S-Ni2 is a bare wire, used for GMAW and GTAW welding.
- ASME Section IX F#6 A#10

APPLICATION

- MIDALLOY ER80S-Ni2 welding wire is used for Tig root passes or Tig & Mig joining for low-temperature, fine-grained steels. These alloys have higher strength and require good toughness at temperatures as low as -60°F.

TYPICAL CHEMISTRY

C	Mn	Si	P	S	Ni	Cr	Mo	V	Cu
.11	1.02	.58	.012	.010	2.35	.04	.01	.002	.14

TYPICAL MECHANICAL PROPERTIES AS WELDED

TENSILE STRENGTH	88,000 PSI (620 KPA)
YIELD STRENGTH	71,950 PSI (510 KPA)
ELONGATION IN 2"	25%
CHARGE IMPACT@ -60°C	38 ft. lbs. Average 50 joules

RECOMMENDED WELDING PARAMETERS

PROCESS	DIA. OF WIRE	AMPERAGE	VOLTAGE	GAS/FLUX
GTAW	1/16" 3/32" 1/8"	50-120 120-200 150-220	7-13 10-16 12-18	Ar Ar Ar
GMAW (MIG) SHORT ARC	.035" .045" 1/16"	90-160 120-200 -	14-20 16-20 -	CO_2 CO_2 or 75 Ar/25 CO_2 CO_2 or 75 Ar/25 CO_2
GMAW (MIG) SPRAY TRANSFER	.035" .045" 1/16"	180-230 250-350 280-400	25-28 25-30 26-36	98 Ar/2 O_2 75 Ar/25 CO_2 75 Ar/25 CO_2

STANDARD PACKAGING

- MIG 33 lb. Spool
- TIG 10 lb. Tubes / 60 lb. Cartons

10/17/13

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Midalloy