



Ni30

SFA-AWS A5.28 ER80S-Ni3
EN ISO 14341-A- W 57P 7 M22 SN71

DESCRIPTION

Low alloy copper-coated solid wire designed for welding low alloy steels with 3,5% Ni content, fine grained for low temperature applications. It is used in petrochemical industry where it finds applications in construction of cryogenic plant and associated pipework, in the manufacture, storage and distribution of volatile liquids and liquefied gases, when operating at temperatures to -100°C.

WELDING POSITIONS



CURRENT

MAG, DC+
TIG, DC-

GAS

(C1, M21, M13)
Ar (I1)

BASE MATERIALS

A 203 Gr D, E, F (BS 1501 Gr 503) A 333 Gr 3 (BS 1503 Gr 503) A 350 Gr LF3 (BS 1504 Gr 503 LT60) A 352 Gr LC3A 203 Gr D, E, F (BS 1501 Gr 503) A 333 Gr 3 (BS 1503 Gr 503) A 350 Gr LF3 (BS 1504 Gr 503 LT60) A 352 Gr LC3

MECHANICAL PROPERTIES

<i>R_m</i> (Mpa)	<i>R_{p 0,2}</i> (Mpa)	<i>A5</i> (%)	<i>KV(j)</i>
630	550	25	40 J (-75° C)

WELD METAL COMPOSITION(%)

C	Si	Mn	P	S	Cu	Cr	Ni	Mo	Al	V	Zr+Ti	Nb
0,1	0,6	1,0	<0,01	<0,01	<0,25	-	3,5	-	-	-	-	-

PACKAGING & WELDING PARAMETERS

Mig (mm)	0,8	1,0	1,2	1,6
Ampere (A)	90-160	150-250	220-320	250-400
Volt (V)	18-22	22-28	26-32	28-36
Tig(mm)	1,6	2,0	2,4	3,2

EQUIVALENT FILLER METALS

MMA	Meltolit 8018-C2 E
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Pre heating temperature 135-165°C, Interpass temperature 135-165°C, post welding heat treatment 620+/-15°C