

TALARC 80Ni-1

CLASSIFICATION

AWS SPECIFICATIONS	EN SPECIFICATIONS
AWS A 5.28: ER80S-Ni1	EN ISO 14341-A: G 50 4 M G3Ni1

ALLOY TYPE

1Ni for good low temperature toughness.

APPLICATIONS

Low alloy copper-coated solid wire designed for welding low alloy steels with 1% Ni content, fine grained for low temperature applications (-50°C). Nickel increases atmospheric weathering resistance and improves electrochemical balance between weld and base metal. Suitable for the construction of offshore platforms, pressure vessels and pipelines. To be used under the shield of Ar+CO₂.

TYPICAL CHEMICAL COMPOSITION OF WIRE

C %	Mn %	Si %	S %	P %	Cr %	Ni %	Mo %	Cu %
0.10	1.10	0.60	0.01	0.01	-	1.00	0.10	0.12

TYPICAL MECHANICAL PROPERTIES

GAS		Yield strength	Tensile strength	Elongation on % 5d	Impact energy (Charpy V)			
		Rs	Rm	A 5d	0°C	-20°C	-40°C	-50°C
		(MPa)	(Mpa)	%	(Joule)	(Joule)	(Joule)	(Joule)
MIX	as welded	530	600	26	-	130	80	60

WELDING GUIDELINES

Preheat and interpass temperature 150°C. PWHT is not required.

TECHNICAL INFORMATION

Gas: Mix Ar- CO₂ (EN 14175)

Welding position: all positions



WELDING PARAMETERS

Current	DC + Reverse polarity		
Diameter (mm)	0.9	1.2	
Volts (V)	17 ÷ 30	18 ÷ 34	
Intensity (A)	70 ÷ 240	100 ÷ 360	

Diam.	15kg Spool
0.9mm	INMNI-109
1.2mm	INMNI-112

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