

TALARC 80Ni-1 TIG

CLASSIFICATION

AWS SPECIFICATIONS	EN SPECIFICATIONS
AWS A 5.28: ER80S-Ni1	EN ISO 636-A: W3Ni1

ALLOY TYPE

1Ni for good low temperature toughness.

APPLICATIONS

Low alloy copper-coated solid wire tig rod 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.

TYPICAL CHEMICAL COMPOSITION OF WIRE

C %	Mn %	Si %	S %	P %	Cu %	Ni %	Cr %	Mo %
0.10	1.10	0.60	0.010	0.010	0.12	1.00	-	0.10

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)
Argon	as welded	530	600	26	-	130	80	-

WELDING GUIDELINES

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

TECHNICAL INFORMATION

Gas: Argon 100% (EN ISO 14175)

Welding position: all positions



WELDING PARAMETERS and PACKAGING DATA

Diameter (mm)	2.4
Length (mm)	1000
Carton	5 Kg
Current	DC - Straight (-) polarity

CDiam.	5kg Tube
2.4mm	INTNi-1 24

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