

# TALARC 80Ni-2 TIG

## CLASSIFICATION

AWS SPECIFICATIONS	EN SPECIFICATIONS
AWS A 5.28: ER80S-Ni2	EN ISO 636-A: W2Ni2

## ALLOY TYPE

2.5Ni for good low temperature toughness.

## APPLICATIONS

Low alloy copper-coated tig rod designed for welding low alloy steels with 2% Ni content, fine grained for low temperature applications. Suitable for the construction of offshore platforms, tanks and pipelines, where good fracture toughness from as-welded joints is demanded down to temperatures in the region of -60°C.

## TYPICAL CHEMICAL COMPOSITION OF WIRE

C %	Mn %	Si %	S %	P %	Cu %	Ni %	Cr %	Mo %
0.10	1.00	0.55	0.010	0.010	0.12	2.30	-	-

## 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	-60°C
		(MPa)	(MPa)	%	(Joule)	(Joule)	(Joule)	(Joule)
Argon	as welded	530	620	26	-	130	80	50

## WELDING GUIDELINES

Preheat and interpass temperature 150°C. PWHT at 620°C for an hour.

## 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

Diam.	5kg Tube
2.4mm	INTNi-2 24

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