

CARBO S-G Ni 2,5 CARBO T-G Ni 2,5

International standards

	S = solid wire	T = bare rod
Werkstoff Nr.		
EN 1668	SG 2 Ni 2	WSG 2 Ni 2
AWS A 5.28	ER80S-Ni2	ER80S-Ni2

Approvals

Application notes

Copper coated, Ni-alloyed solid wire for application in all positions for welding low alloyed cryogenic steels useable down to -80°C . For thin sheets and root pass welding.

Operating temperature down to -80°C

Base materials

Cryogenic constructional steels and Ni-steels, cryogenic steels for ship building
S235NL2, S255NL2, 14Ni6, 12Ni14, X12Ni5, S255NL, S380NL, S255NL1, S380NL1,
ASTM A633 Gr. E; A572 Gr.65; A203 Gr. D; A333 and A334 Gr.3; A350 Gr. LF3

Mechanical properties of all-weld-metal with Gas: M 21 (typical values)

Tensile strength R_m N/mm ²	Yielding strength $R_{p0,2}$ N/mm ²	Elongation A_5 %	Impact strength ISO – V J at -80°C
> 610	>510	>22	>47

Weld metal analysis (typical, wt %)

C	Si	Mn	Ni
0,09	0,5	1,0	2,5

Gas types EN 439

S = solid wire
M2, M3, C1

T = bare rod
I1 (Argon)

Current

Diameter mm	= +				= -				
	0,8	1,0	1,2	1,6	1,6	2,0	2,4	3,2	4,0
Welding amps (A) min.	80	120	180	250					
(A) max.	130	190	250	320					

coils, weight

B300 15 kg.

25 kg.

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