

Standards

TS EN ISO 14341-A	: G3Ni 1
TS EN ISO 636A	: W3Ni1
EN ISO 14341-A	: G3Ni 1
EN ISO 636A	: W3Ni1
AWS A5.28	: ER 80S-Ni1

Chemical Composition of Welding Wire % (Typical)

C	Si	Mn	Ni
0.08	0.65	1.10	1.0

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/-45°C)	Elongation (L ₀ =5d ₀) (%)
min. 470	min. 550	min. 27 J	min. 24

Typical Base Material Grades

- A106; A515; A714; A131; A369; A210; L290; P235 T1 /T2; P275 T1;
- L360; L415; P275T2; P355N; API X-42; X46; X62; X60; P235GH; P355GH;
- A283; A285; A414; A372; A662; S275; S420; A516; A255; A333; A350; A612

Features and Applications

- Building up of cranes, transport, industrial facilities, equipment in general, pipelines, shipbuilding, etc
- Working temperatures are between of -45°C and +400°C
- Shielding gas: Ar+CO₂ mix gases can be used for MAG
- Shielding gas: Ar gas can be used for TIG

Welding Positions



Current Type

TIG D.C.(-) / MAG D.C.(+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
3031100169	1.20	0.047"	15	BS 300 Spool
6011100373	2.0 x 1.000	5/64 x 39"	5	Carton Box
6011100380	2.4 x 1.000	3/32 x 39"	5	Carton Box

Approvals: CE, SEPRO