

Standards

TS EN ISO 14341-A	: G2Ni 2
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AWS A5.28	: ER80S-Ni2

**Chemical Composition of
Welding Wire % (Typical)**

C	Si	Mn	Ni
0.08	0.55	1.10	2.30

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/-60°C)	Elongation ((L ₀ =5d ₀) (%))	Heat Treatment
min. 470	min. 550	min. 27 J	min. 24	620 ± 15°C / 1 hours

Typical Base Material Grades

- S255NL2-S355NL2; 14Ni6; 12Ni14; X12Ni5; S255N, S380N, S255NL, S380NL;
S255NL1-S355NL1; S380NL1;
- A333: Gr.1-3; A442; Gr55-60; A334: Gr.3;
- 10Ni14, 13MnNi63 ; TTSI E355; TTSI E 460; HY 80; TTSE 35 N

Features and Applications

- Applications down to -60°C on mild steels, low-alloy steels and fine-grained steels, plates, storage tanks, pipelines and equipment for cryogenic use
- Shielding gas: Ar+CO₂ mix gases can be used

Welding Positions

Current Type

MAG D.C.(+)

Operating Data

Product Code	Diameter (mm) / (inch)		Weight (Kg)	Package Type
3031100170	1.20	0.047"	15	BS 300 Spool

Approvals: CE, SEPRO