

MIDALLOY ER80S-Ni 1 WELDING WIRE

CLASSIFICATION

- AWS A5.28 Class ER80S-Ni1 / ASME SFA 5.28 Class ER80S-Ni1

DESCRIPTION

- MIDALLOY ER80S-Ni1 is a copper-coated wire, used for GMAW and GTAW welding.

APPLICATION

- MIDALLOY ER80S-Ni1 welding wire is used for Tig root passes or Tig & Mig joining of carbon manganese high strength steels, requiring good toughness at temperature as low as -50°F.

TYPICAL CHEMISTRY

C	Mn	Si	P	S	Ni	Cr	Mo	V	Cu
.11	1.02	.58	.012	.010	.92	.04	.01	.002	.14

TYPICAL MECHANICAL PROPERTIES

TENSILE STRENGTH	87,000 PSI
YIELD STRENGTH	73,950 PSI
ELONGATION IN 2"	25%
CHARPY IMPACT @ -50°F	44.22 ft. lbs.

RECOMMENDED WELDING PARAMETERS

PROCESS	DIA. OF WIRE	AMPERAGE	VOLTAGE	GAS/FLUX
GTAW	1/16"	50-120	7-13	Ar
	3/32"	120-200	10-16	Ar
	1/8"	150-220	12-18	Ar
GMAW (MIG) SHORT ARC	.035"	90-160	14-20	CO ₂
	.045"	120-200	16-20	CO ₂ or 75 Ar/25 CO ₂
	1/16"	-	-	CO ₂ or 75 Ar/25 CO ₂
GMAW (MIG) SPRAY TRANSFER	.035"	180-230	25-28	98 Ar/2 O ₂
	.045"	250-350	25-30	75 Ar/25 CO ₂
	1/16"	280-400	26-36	75 Ar/25 CO ₂

STANDARD PACKAGING

- TIG 50 lb. carton
- MIG 33 lb. spool

3/2/09

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