



## F 80S-Ni1

**CODIFICATION:** AWS : SFA 5.28 ER80S-Ni1

### CHARACTERISTICS AND APPLICATIONS:

F 80S-Ni1 is a copper-coated solid wire available in bright finish, gives smooth flow, stable arc and spatter free under optimum welding conditions. It is specially designed to produce weld metal with increase strength and notch toughness at temperature up to minus 45°C. It gives radiographic quality welds. Ideally suitable for welding fine grained and Nickel steels. Typical applications include storage tanks for liquefied gases, distillers in coke oven batteries and petrochemical industries.

### TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

Element	C	Mn	Si	S	P	Ni	Cr	Mo	V	Cu
%	0.06	0.50	0.60	0.010	0.012	1.00	0.05	0.25	0.02	0.20

### TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	YS (MPa)	Elongation (L = 4d) %	CVN Impact strength at minus45°C(Joules)
600	520	28.0	75

**SHIELDING GAS:** Argon

**CURRENT CONDITION:** DCEN

**WELDING POSITION:** H, F, VU, OH

### PACKING:

**STANDARD SIZE:** Diameter 1.6 mm, 2.0 mm, 2.4 mm & 3.2 mm in cut lengths of 500 mm / 1000 mm each.

**QUANTITY** 5 kg wire put in an air-tight polythene bag and finally packed in a plastic container.

Identification – AWS code is punched on each wire.