Estd. 1966
D&H sécheron
Complete Welding Support

50 YEARS 1968 - 2018

F 80S-Ni2

CODIFICATION: **AWS** : SFA 5.28 ER80S-Ni2

CHARACTERISTICS AND APPLICATIONS:

F 80S-Ni2 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 60°C. It gives radiographic quality welds. Ideally suitable for welding fine grained and Nickel steels. Typical applications include containers and piping systems and tanks used for storage, transportation of liquefied propane and butane, A&P brackets etc.

TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

Element	C	Mn	Si	S	P	Ni	Cu
%	0.06	0.50	0.60	0.010	0.012	2.50	0.20

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

(PWHT: 620°C FOR 1 HR)

UTS (MPa)	YS (MPa)	Elongation (L = 4d) %	CVN Impact strength at minus60°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.