

CARBO S-G Ni 2,5

CARBO T-G Ni 2,5

International standards

	S = massive wire	T = bare rod
Werkstoff Nr.		
EN 1668	SG 2 Ni 2	WSG 2 Ni 2
AWS A 5.28	ER80S-Ni2	ER80S-Ni2

Approvals

Application notes

Copper coated, Ni-alloyed massive wire for application in all positions for welding low alloyed cryogenic steels useable down to - 80°C. For thin sheets and root pass welding.

Operating temperature down to -80° C

Base materials

Cryogenic constructional steels and Ni-steels, cryogenic steels for ship building
S235NL2, S255NL2, 14Ni6, 12Ni14, X12Ni5, S255NL, S380NL, S255NL1, S380NL1,
ASTM A633 Gr. E; A572 Gr.65; A203 Gr. D; A333 and A334 Gr.3; A350 Gr. LF3

Mechanical properties of all-weld-metal with Gas: M 21 (typical values)

Tensile strength R_m N/mm ²	Yielding strength $R_{p0,2}$ N/mm ²	Elongation A_5 %	Impact strength ISO – V J at -80° C
> 610	>510	>22	>47

Weld metal analysis (typical, wt %)

C	Si	Mn	Ni
0,09	0,5	1,0	2,5

Gas types EN 439

S = massive wire
M2, M3, C1

T = bare rod
I1 (Argon)

Current

		= +				= -				
Diameter	mm	0,8	1,0	1,2	1,6	1,6	2,0	2,4	3,2	4,0
Welding amps	(A) min.	80	120	180	250					
	(A) max.	130	190	250	320					

coils, weight

B300 15 kg.

25 kg.

Rev. 000