



SELECTARC MIG F81

Old reference : MIG 80SNi1

Classification

AWS A5.28 : ER80S Ni 1

ISO 14341-A

: G3 Ni 1

Characteristics

GMAW wire alloyed with Nickel for welding low-alloy steels with high Yield strength. Resistant to low temperature down to -60°C. For weld joints exposed to low temperature.

Application

Off-Shore, Crane, Vessel, Rings, Platform, Pipeline, Boiler, Tubing etc.

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	P	S	Fe
0.10	0.45	1.10	0.10	1.00	0.03	0.20	0.018	0.010	base

All Weld Metal Mechanical Properties (Typical)

Conditions	UTS	YS	% Elg	Impact (KV)	
	R _m (MPa)	R _{p0.2} (MPa)		Temp.°C	J
AW	600	500	26	- 20	130
				- 60	50

Welding Current & Instructions

Welding Mode	Wire Ø (mm)	Welding Mode		Shielding Gas ISO 14175
		(A)	(V)	
MIG = +	1.0	150 - 170	25 - 28	M21 (Ar/CO ₂) C1 (100% CO ₂) 12-15 l/min
	1.2	180 - 250	26 - 28	

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