



MIG F82

Old reference: MIG 80SNi2

Classification

AWS A5.28 : ER80S-Ni2

ISO 14341-A : G 46 8 M GN5

Description & Applications

GMAW wire electrode to weld under shielding gas fine grain construction steels and nickel alloyed steels. Resistant to low temperature down to -60°C. Good characteristics of cold toughness. Frequently used for liquid gas distribution pipes, tanks, off shore, and petro-chemistry.

Base materials

High strength steels, fine grain construction steels, cold tough:

EN	ASTM
12Ni9 1.5635	
14Ni6 1.5622	A352 gr. LC2
13MnNi6-3 1.6217	
S/P275-S/P420	A516 / A255 / A299 / A333 / A350
P235T1/2-P355N	A369 / A210/ A106
L210-L485	
S255 - S550	A516 / A255 / A333 / A350 / A612 / A714

Typical Weld Metal Composition (%)

C	Si	Mn	Ni	Mo	P	S	Fe
0.08	0.6	1.1	2.5	0.05	<0.02	<0.02	Rem.

All Weld Metal Mechanical Properties

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
500	600	22	-20 °C 130 -40 °C 80 -80 °C 50

Weld Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
MIG =+	1.0	150-170	25-28	ISO 14175: M21 (Ar/CO ₂) 12-15 l/min
	1.2	180-250	26-28	

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