

## Classifications

AWS A5.28	EN ISO 14341-A	GB/T8110
ER80S-G(Ni1 mod.)	G 50 5 M 21 3Ni1	ER55- G(Ni1 mod.)

## Characteristics and typical fields of application

- Very good weldability in out of position work; Excellent cold toughness at - 60°C.
- Low content trace elements. Suited for welding 1Ni or 16MnDR steel and other low temperature for low temperature pressure vessel, tank and pipe.

## Base materials

P235GH,P265GH,P-S460NL,15MnNi 63.

## Typical analysis of all-weld metal (Wt.%)

C	Si	Mn	P	S	Ni	Cr	Mo	Al	V	Cu
0.10	0.70	1.4	0.005	0.003	1.40	0.03	0.02	≤0.02	≤0.03	0.10

## Mechanical properties of all-weld metal – typical values (min. values)

Condition	R <sub>p0,2</sub>	R <sub>m</sub>	A <sub>4</sub>	K <sub>V</sub> (J)	
	Mpa	Mpa	%	-45°C	-60°C
620°C/1h (M21)	570(≥470)	660(≥550)	29 (≥24)	130(≥47)	80 (≥27)

## Operating data

	Polarity:	Size(mm)	Shielding Gas:
	DC +	1.0 1.2	(ISO 14175) M21

## Approvals

CE,DNV-GL,ABS