



SELECTARC TIG F81

Old reference : TIG 80SNi1

Classification

AWS A5.28 : ER80S-Ni 1

EN ISO 636

: W3 Ni 1

Characteristics

GTAW coppered rod alloyed with Nickel for welding low-alloy steels with high Yield strength. Resistant to low temperature down to -40°C.

Applications

For weld joints exposed to low temperature.

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	V	P	S	Fe
0.10	0.60	1.10	0.10	1.00	0.12	0.20	0.008	0.020	0.015	base

All Weld Metal Mechanical Properties (Typical)

Conditions	UTS	YS	% Elg A ₅	Impact (KV)	
	R _m (MPa)	R _{p0.2} (MPa)		Temp. °C	J
AW	600	500	26	- 20	130
				- 45	80

Welding Current & Instructions

Welding Mode	Shielding Gas
TIG = -	Ar : 6 - 12 l/min Back shielding : N ₂ /H ₂ : 3 - 6 l/min

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