

## IABCO ER80S-Ni2 MIG

### MIG/GMAW wire for low alloy steels

Product name	IABCO ER80S-Ni2 MIG
Classification EN ISO	14341-A: G 2Ni2 / G 46 4 M21 2Ni2
Material No.	-
Classification AWS	A5.28: ER80S-Ni2
Approvals	TÜV 12693.00, CE.
Applications	MIG/GMAW wire for steels where impact properties are required down to -75°C. Applications include structural, oil & gas and offshore steelwork.
Base materials	For cryogenic construction steels and Ni bearing low temperature steels. ASTM: A203 grade A/B, A333/A334 grades 1/6/7, A350 grade LF2/LF5/LF6, A352 grade LC1/LC2. 11MnNi5-3, 13MnNi6-3, S275NL-S460NL, S275ML-S460ML, P275NL2-P460NL2, P355ML2-P460ML2.
Typical analysis of wire, weight %	C: 0.09 Si: 0.52 Mn: 1.10 Ni: 2.45
Typical heat treatment <sup>(1)</sup>	Preheat and PWHT are often not necessary but actual requirements will depend on the grade and thickness of material being welded and any design codes that apply.
Mechanical properties of weld deposit <sup>(2)</sup>	0.2% proof stress Rp0.2%: ≥470MPa. Tensile strength Rm: ≥550MPa. Elongation 4d/5d: ≥24/20%. Impact ISO-V, -40°C: ≥47J and -60°C: ≥27J.
Other products	SAW: S2Ni2. TIG/GTAW: ER80S-Ni2.

**Notes** (1) Application codes and project specifications should always be referred to for specific requirements.

(2) Actual mechanical properties will be dependent on specific welding procedure (including shielding gas, flux, PWHT etc) and should always be confirmed by approval of an appropriate welding procedure.