Inweld 80S-Ni2

AWS A5.28 ER80S-Ni2

Chemical Composition of Inweld 80S-Ni2

C	Mn	Si	P	S	Ni	Cr	Mo	V	Cu	Other
0.12	1.25	0.40-0.80	0.025	0.025	0.80-1.10	0.15	0.35	0.05	0.35	0.50

Single values are maximum unless otherwise specified.

Description and Applications

Inweld 80S-Ni2 is similar to 8018-C1 wire. Typically, they are used for welding 2.5 nickel steels and other materials requiring good toughness at temperatures as low as -80ºF (-60ºC).

Procedure

Typical Weld Metal Properties

	AWS Spec (psi)
Tensile Strength:	80,000
Yield Strength:	68,000
Elongation:	24%

Recommended Parameters

GMAW, GTAW - Ar/1-5% O_2

Wire Diameter	Voltage	Amperage