



ED ER80S-Ni1

Manufactured by **FLIESS-GERMANY**

GMAW wires for low and weathering grade steels – **AWS A5.28/ASME SFA- A5.28 ER80S-Ni1**

Key Characteristics

- MIG/GMAW Wire for low temperature service
- For cryogenic construction steels
- For steels where impact properties required are at 60°C

Typical Applications

- Structural, oil, gas, offshore steel work

Base Material

Cryogenic and Ni bearing construction steels
ASTM A333/A334 Grade 1/6
A350 Grades LF2/LF6
A352 Grades LCB/LCC
API 5L/X65

Typical Analysis %

Typical Wire Composition	%C 0.09	%Mn 1.05	%Si 0.50	%S 0.010	%P 0.005
Typical Wire Composition	%Cr 0.04 max	%Ni 0.9	%Mo 0.02 max	%Cu 0.21 max	%Ti 0.05

Mechanical Properties

	Y.S. MPa (ksi)	T.S MPa (ksi)	Elongation %	Impact Energy J
Typical Results (all weld metal) As welded	470 MPa	550 MPa	4d/5d 24	-60C 47 J

Ordering Information

Product Number	Product (AWS Specification)	Dimension mm/inches	Single Tube Weight kg/lb	Box Weight kg/lb
437090115	ED ER80S-Ni1 (ER80S-Ni1)	0.9 mm (0.035")	15.0 kg (33.0 lb)	15.0 kg (33.0 lb)
437120115	ED ER80S-Ni1 (ER80S-Ni1)	1.2 mm (0.045")	15.0 kg (33.0 lb)	15.0 kg (33.0 lb)

