Revis® 80S-Ni2

Mild steel solid wire

Classification

AWS A5.28	:ER80S-Ni2
EN 1668	:W 46 6 W2Ni2
EN 440	:G 46 6 M G2Ni2

General Description

Solid wire for welding fine grained and low alloyed nickel steels
High impact value at low temperature (-70°C).
Typical offshore applications

Shielding gases (acc. EN 439)

GTAW	I1	Inert gas Ar 100%
GMAW	M21	Mixed gas Ar+ >5-25% CO_2

Approvals

	TÜV
GTAW	+
GMAW	+

Chemical composition (w%), typical, all weld metal

C	Mn	Si	Ni
0.1	1.1	0.6	2.5

Mechanical properties, all weld metal

	Process	Shielding gas	Condition	Yield Strength (N/mm^2)	Tensile Strength (N/mm^2)	Elongation (%)	Impact (ISO), J -62 °C	-70 °C	-90 °C
Typical values	GTAW	I1	AW	525	610	28	280		170
after welding	GTAW	I1	SR 580°C/15h	500	570	30	230		180
	GMAW	M21	AW	490	580	24	105	50	
			SR 580°C/15h	420	535	29	150		140

Materials to be welded

Steel	Code	Type
General structural steel	EN 10025	S355
Pipe material	EN 10208-2	L360, L415, L445
	API 5LX	X52, X56, X60, X65
Fine grained steel	EN 10113-2	S355, S420
	EN 10113-3	S355, S420
Low temperature steel	EN 10028-4	11MnNi 5-3, 13MnNi 6-3, 15 NiMn 6 (12 Ni 14 G 1, C2)
	EN 1022-3	13 MnNi 6-3, 15 NiMn 6

Packaging, available sizes and identification

Process	Unit:	Sizes, mm 1.0	1.2	2.0	2.4
GTAW	2 and 5 kg tube			X	X
GMAW	15 kg spool B300	X	X		

Other sizes and packaging on request

Identification	Imprint: Revis®80S-Ni2	Tip colour:	**Revis®80S-Ni2 : rev.EN 20**