

ZULFI SW ER80S-Ni1

CLASSIFICATION

AWS A5.28	ER80S-Ni1
EN ISO 636-A	W 46 6 M G3Ni1

APPROVALS

ABS
BV
DNV
LRS

GRADE

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PROPERTIES

ZULFI ER80S-Ni1 is a copper coated precision layered wire depositing a C-0.8Mn-1.0Ni weld metal. Weld metal with 1.0%Ni makes this electrode suitable for lower temperature application down to -60°C. Suitable for use with Argon shielding gas, CO2 and Mixed gas.

APPLICATIONS

Used for 1%Ni steels and fine grain steels, when application toughness properties down to -60°C. ASTM A588 weathering steel requiring good atmospheric corrosion resistance, NACE applications and shipping grade steels DH36 and EH36.

CHEMICAL ANALYSIS [TYPICAL VALUES IN %]

CONDITION	C	Mn	Si	P	S	Ni	Mo	Cr
Wire	0.08	1.10	0.60	0.015	0.015	1.0	0.02	0.03
Weld metal (CO2)	0.065	0.90	0.30	0.014	0.013	0.95	0.02	0.01

CURRENT CONDITION & WELDING POSITION

DC+

ALL-WELD METAL MECHANICAL PROPERTIES

CONDITION	YIELD STRENGTH (MPa)	TENSILE STRENGTH (MPa)	ELONGATION %	IMPACT STRENGTH
As welded (CO2)	≥ 480	550 - 680	≥ 22	60J at -60 °C

PACKING DATA

DIAMETER (MM)	VOLTAGE (V)	CURRENT (A)	GAS FLOW RATE (LPM)	WEIGHT PER TUBE (KG)
0.80	17-27	80-250	12-18 (100% CO ₂) 17-22 (ArCO ₂)	15
1.0	18-30	100-350		15
1.20	20-34	120-400		15
1.60	22-36	150-450		15