

MIGWELD 2,5Ni

MIG/MAG Wires [GMAW]

Low alloyed steel

| | | |
|---|-------------------|---|
| CLASSIFICATION: EN ISO 14341-A : G 46 7 M21 2Ni2 AWS A-5.28 : ER 80S-Ni2 | APPROVALS: | APPLICATION: Constructions & Engineering Petrochemical and chemical industry |
|---|-------------------|---|

- Solid copper coated welding wire.
- For welding low-alloy steels as well as high-strength and fine-grained steels, working at low temperatures (up to -60°C).
- Oil, gas, offshore applications.



Base material

| EN 10088-1/2/DIN 17280-85 | W.Nr. |
|---|--------|
| 11MnNi5-3 | 1.6212 |
| 13MnNi6-3 | 1.6217 |
| 15NiMn6 | 1.6210 |
| 10Ni14 | |
| 12Ni14 | 1.5637 |
| Steels S275NL-S460NL, S275ML-S460ML | |
| Pipelines P275NL2-P460NL2, P355ML2-P460ML2 | |
| ASTM: A203 g.A/B, A333/A334 g 1/6/7, A350 g. LF2/LF5/LF6, A352 g. LC1/LC2 | |

Typical chemical composition %

| C | Si | Mn | Ni |
|------|------|------|------|
| 0,09 | 0,50 | 1,10 | 2,45 |

Typical mechanical properties

| | |
|--|---|
| Yield strength Re [N/mm ²] | >460 |
| Tensile strength Rm [N/mm ²] | 530-680 |
| Elongation A5 [%] | 20 |
| Impact energy Kv [J] | >47J (-70°C) / |
| Wire/rod type | solid |
| Heat treatment | Not required |
| Welding current |  |
| Welding positions |  |
| Shielding gases acc. to EN ISO 14175 | M21 - Ar + 15 - 25% CO ₂ / |

Welding parameters and packing

| ∅ | Welding current [A] | Voltage [V] | Weight of packet [kg] |
|-----|---------------------|-----------------|-----------------------|
| 1,0 | 80-95 | 17-19 short arc | 15,0 |
| 1,0 | 240-270 | 24-27 spray arc | 15,0 |
| 1,2 | 110-130 | 18-20 short arc | 15,0 |
| 1,2 | 270-320 | 27-32 spray arc | 15,0 |

METALWELD-FIPROM POLSKA spółka z o.o.

ul. Mikołajczyka 57, 41-200 Sosnowiec

+48 (32) 297 75 50 - 51

+48 (32) 297 75 88

export@metalweld.pl