

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
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- 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

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