

MIGWELD Ni1

Electrodes MMA [SMAW]

Construction, unalloyed steels

CLASSIFICATION: EN ISO 14341-A : G 50 6 M21 3Ni1 AWS A-5.28 : ER 80 S-Ni1	APPROVALS:	APPLICATION: Constructions & Engineering Petrochemical and chemical industry
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- Solid copper coated welding wire with Ni for welding in gas shielding atmospheres.
- Recommended for higher grade construction steel with tensile strength up to 685 N/mm² and elements working in low temperatures.



Base material

EN 10088-1/2/DIN 17280-85	W.Nr.
11MnNi5-3	1.6212
13MnNi6-3	1.6217
S185-S355-S460	
P235GH, P355GH, P235T1/T2, P460NL2	
L210-L480MB	
S255-S460(NL1,2)	
X42, X65	
ASTM A258/A516, A662/A387, A738/A612, A299	
DIN A, B, D, E, AH 32-EH36, St33, St37-2-St52-3, HI, HIII, 17Mn4, 19Mn5, St35.8, St45.8, StE210.7TM, StE 480.7TM, StE255-StE460, X42, X65	

Typical chemical composition %

C	Si	Mn	Ni	P	S
0,08	0,80	1,50	1,10	<0,025	<0,025

Typical mechanical properties

Yield strength Re [N/mm ²]	>500
Tensile strength Rm [N/mm ²]	560-720
Elongation A5 [%]	18
Impact energy Kv [J]	>47] (-60°C) /
Wire/rod type	solid
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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