



Unibraze 80S-NI2

(ER80S-NI2)

Classification:

AWS A5.28 / ASME SFA5.28 Class ER80S-NI2

Description:

Unibraze 80S-NI2 is a mild steel solid wire that contains over 2% nickel. It will give radiographic quality welds with excellent bead appearance and is suitable for single and multiple pass welding. Unibraze 80S-NI2 is used for welding of fine grain structural steels if low temperature impact values are required. For service temperatures down to -60 °C.

Typical Chemical Composition:

Carbon	0.1
Silicon	0.6
Manganese	1.1
Nickel	2.4

Typical Mechanical Properties:

Tensile Strength	91,300psi
Yield Strength	78,300 psi
Elongation % in 2"	28.0%

Typical Charpy V-Notch Impact Values:

Avg. at 32°F	(0°C)	95 ft-lbs
Avg. at -40°F	(-40°C)	73 ft-lbs
Avg. at -76°F	(-60°C)	44 ft-lbs

Typical Welding Parameters: (DC+)

Diameter	Amps	Volts	Wire Feed Speed
.035"	80-280	18-28	100-525 in/min
.045"	120-350	20-33	100-480 in/min
1/16"	225-480	26-38	125-300 in/min

Notice: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for use in the field. The manufacturer disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.