



AWS A5.28: ER80S-Ni2
EN 440 46 5 M G2Ni2

Solid wire

Welding of Low Temperature Steel

MS-A802

DESCRIPTION & APPLICATION

MIG/TIG Filler Wire for the joining of Steel operating at low temperatures. Excellent impact values at -50°C Improved resistance to preferential corrosion therefore ideal for welding rebar and ties in external applications.

BASE MATERIALS

BS 4360 WR50A-WR50C
ASTM A588 grades A,B,C,K

Din. 1.8960, 1.8961, 1.8963

MECHANICAL PROPERTIES

>630

UTS n/mm

>540

YIELD 0.2%

>25

ELONG A5%

>60

CHARPY (J) -20°C

METAL WELD COMPOSITION %

C

0.1

Si

0.6

Mn

1.1

Ni

2.3

Cu

0.2

Fe

BAL

PACKAGING

15kg Spools (MIG)
5kg Tubes (TIG)

DIAMETERS

0.8, 1.0, 1.2mm (MIG)
1.6, 2.4, 3.2mm (TIG)

WELDING INSTRUCTIONS

MIG Shielding Gas 5% or 20% CO₂ in Argon or proprietary mix. TIG 100% Argon.