

## TIG Rods C-Mn steels and low-alloy steels

Carborod Ni 2 is a TIG rod suitable for welding low alloy and 2% Ni steels for low temperature applications. Excellent mechanical properties both in the as-welded and stress relieved conditions.

Classification	
AWS	A5.28: ER 80S-Ni2
EN	1668: W 46 6 M W2Ni2

Approvals	Grades
TÜV	

see Appendix, Classification Society Approvals, for details pag. 521

### Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.08	1.10	0.50	≤ 0.020	≤ 0.020	-	2.50	-	-	-	-	-

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation A5 (%)	Impact Energy ISO - V (J) -60°C	Hardness
As Welded	≥ 470	550-680	≥ 20	≥ 47	-

Gas test: Acc. To EN 439: I1(Arcal1)

**Shielding Gas:** Acc. To EN 439: I1(Arcal1)

### Materials

S(P)275-S(P)420

### Storage

Keep dry and avoid condensation

### Current condition and welding position

DC-



**Packaging data:** Tube 5 kg

Diameters (L: 1000 mm)	1,6	2,0	2,4	3,2		
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Further forms of delivery on request.