

ER 80S-Ni2

Specifications

AWS 5.28

ASME SFA 5.28

Technical Data Sheet

Chemical Composition Limits								
Weight%	C	Mn	Si	P	S	Ni	Cu	OET
ER 80S-Ni2	0.12 max	1.25 max	0.40-0.80	0.025 max	0.025	2.00-2.75	0.35 max	0.50 max
	0.05	0.81	0.510	0.002	0.006	2.670	0.12	0.30

TOKO brand, alloy ER80S Ni2 are used for welding 2.5 % nickel steels and other materials requiring a tensile strength of 80 ksi (550MP) and good toughness at temperatures as low as -80°F (-62°C). The weld deposits of this filler metal are similar to E8018 - C1 electrodes.

Typical Mechanical Properties

Material	Ultimate Tensile Strength		Offset Yield Strength 0.2 %		Elongation (%)
	psi	MPa	psi	MPa	
ER 80S-Ni2	89,900	610	76,850	520	28

Availability

TOKO brand, alloy ER 80S-Ni2 is a mild and low alloy steel TIG, MIG and SUB-ARC wire used for welding. For all stock availability contact us via office@tokoc.com

The information contained or otherwise referenced herein is presented only as “typical” without guarantee or warranty, and TOKO Corporation expressly disclaims any liability incurred from any reliance thereon. Typical data and Test results for mechanical properties, deposit or electrode composition and other properties were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application.

