

# LNT Ni1

## Key Features

- Solid TIG rod for welding low alloy steels
- High impact value at low temperatures -60°C
- Resealable PE Tube
- Ni content is controlled to meet “sour service” oilfield requirements such as NACE MR0175

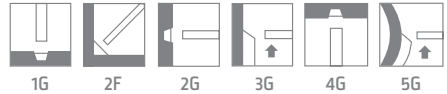
## Typical Applications

- Offshore Oil & Gas
- Small diameter pipe and tubing

## Conformances

**AWS A5.28/A5.28M:** ER80S-Ni1  
**EN ISO 636-A:** W 42 6 W3Ni1

## Welding Positions



## Shielding Gas

- 100% Argon
- Flow rate 10-15 L/min

## Diameter / Packaging

Diameter mm	Length mm	Part Number	Packaging
2.4	1000	605136	PE Tube 5kg

## Mechanical Properties - As required per AWS A5.28

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J@
<b>Requirements</b> - AWS ER80S-Ni1	470 min	550 min	24 min	27 @ -45°C
<b>Typical Results</b> - As Welded	480	580	30	60 @ -60°C

## Wire Composition

	%C	%Mn	%Si	%Ni
<b>Typical Results</b>	0.10	1.2	0.6	0.9