

LNM Ni-1

Key Features

- Solid nominal 1% Ni wire for welding Carbon Manganese and low alloy steels
- Stable arc and excellent feedability
- High impact values @ -60°C

Conformances

AWS A5.28/A5.28M: ER80S-Ni1
AS/NZS 14341-A: G 46 5 M G3Ni1

Typical Applications

- Suitable for offshore, oil and gas industries
- Complies with NACE 1% Ni limits
- Up to API 5LX X65 grade pipe steels
- Weather resistant steels - i.e. COR-TEN

Welding Positions



Shielding Gas

- M21 : 75-85% Argon / 15-25% CO₂
- Flow Rate: 15-20 L/min

Diameter / Packaging / Settings

Diameter mm	Part Number	Packaging	WFS ipm	Voltage volts	Current amps	CTWD mm
1.0	582468	Basket B300 ¹ 15kg	125-400	19-28	145-350	15-20

1. B300 wire basket (2158341 adaptor required)

Mechanical Properties - As required per AWS A5.28

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

Wire Composition

	%C	%Mn	%Si	%Ni
Typical Results	0.09	1.2	0.6	0.9