

Pipelin[®]er 80Ni1

TOP FEATURES

- Root pass capability up to X100 and hot, fill and cap pass up to X80 grade pipe
- Impact toughness capable of exceeding 69 - 95 J at -50°C
- Excellent wire placement for narrow groove welding

TYPICAL APPLICATIONS

- Root pass welding on up to X100 grade pipe
- Hot, fill and cap pass welding on up to X80 grade pipe
- Pipeline
- Offshore

CLASSIFICATION

AWS A5.28 ER80S-G
EN ISO 14341-A G 3Ni1

SHIELDING GASES (ACC. EN ISO 14175)

C1 Active gas 100% CO₂
M20/M21 Mixed gas 75-95% Ar/Balance CO₂

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, WIRE

C	Mn	Si	P	S	Ni	Mo	Ti	Al
0.07	1.55	0.70	0.11	0.10	0.90	<0.01	0.08	<0.01

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)	
						-29°C	-50°C
Required: AWS A5.28			-	min. 550	-	-	-
	C1	AW	600	665	28	80	45
	M20	AW	650	730	27	110	70

* AW = As welded

- = not specified

AVAILABLE SIZES AND PACKAGING INFORMATION

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.0	SPOOL	15.0	ED033119
1.2	SPOOL	15.0	ED033120

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels 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

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.eu for any updated information.