

CARBOFIL NI2

TOP FEATURES

- Excellent mechanical characteristic both when welded and after stress relieving.
- High impact value at low temperature (-60°C as welded and -90°C after stress relieving 15h/580°C)
- Ideal for low temperature applications.

TYPICAL APPLICATIONS

- LNG
- Cryogenic Applications

CLASSIFICATION

AWS A5.28 ER80S-Ni2
EN ISO 14341-A G 46 7 M21 2Ni2

SHIELDING GASES (ACC. EN ISO 14175)

M21 Mixed gas Ar+ >15-25% CO₂

APPROVALS

TÜV	CE
+	+

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, WIRE

C	Mn	Si	P	S	Ni
0.08	1.1	0.5	≤0.020	≤0.020	2.3

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)		
						+20°C	-70°C	-90°C
Typical values	M21	AW	≥460	550-680	≥22	>120	≥47	
	M21	PWHT 580°C x 15h	≥460	550-680	≥22	≥130	≥70	≥47

* AW = As welded, PWHT = Post Welding Heat Treatment

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.2	SPOOL (B300)	16.0	W000282982

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.