

# SAFER ND 80

## TOP FEATURES

- The weld metal is of extremely high metallurgic purity, retaining good ISO-V toughness up to -40°C. The SAFER ND 80 is used for applications with a higher yield strength up to 700 Mpa and down to -40°C.
- Easy striking.
- 120% efficiency

## CLASSIFICATION

AWS A5.5 E11018-G H4  
EN ISO 18275-A E 69 6 Mn2NiMo B 42 H5

## CURRENT TYPE

AC, DC+

## WELDING POSITIONS

All position, except vertical down

## APPROVALS

CE

+

## CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	P	S	Cr	Ni	Mo
0.065	1.85	0.35	≤0.02	≤0.012	<0.2	2.6	0.4

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Required	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -60°C
AWS A5.5	AW or PWHT**	≥670	≥760	≥15	not specified
EN ISO 18275-A	AW	≥690	760-960	≥17	≥47
Typical values	AW	≥690	770-940	≥20	≥80

\*AW: As-welded; PWHT: Postweld Heat Treatment

\*\*PWHT: In accordance with the agreement between the purchaser and the supplier.

## OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 350	65-90
3.2 x 350	85-145

## PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 350	VPMD	89	2.1	W000380842
3.2 x 350	VPMD	60	2.1	W000380278

## 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](http://www.lincolnelectric.eu) for any updated information.