

## TIG Rods C-Mn steels and low-alloy steels

CARBOROD Ni2 is a copper coated W2Ni2 / ER 80S-Ni2 type solid TIG welding rod depositing a C-0.8Mn2.3Ni weld metal. Suitable for use with Ar shielding gas.

CARBOROD Ni2 is used for the welding of 2%Ni-steels, when the weld metal toughness properties to -90°C are required in the as welded conditions.

Classification	
EN ISO	636-A: W 46 9 W2Ni2
AWS	A5.28: ER 80S-Ni2

### Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Ni
0.08	1.1	0.5	≤ 0.015	≤ 0.015	2.3

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)		
				+20 °C	-70 °C	-90 °C
As Welded	≥ 460	550-680	≥ 24	≥ 150	≥ 60	≥ 47


Gas test: 100% Ar

**Shielding Gas** - EN ISO 14175 : I1

### Materials

S(P)275 - S(P)460

Storage
Keep dry and avoid condensation

Current condition and welding position
DC-

PA PB PC PD PE PF PG

### Packaging data

Diam. (mm)	Packaging Type	Weight (kg)	Code
1.6	TUB	5	●
3.2	TUB	5	●