

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

CARBOROD Ni3 is an ER 80S-Ni3 type solid TIG welding rod depositing a C-1.0Mn3.2Ni weld metal. Suitable for use with mainly Ar shielding gas.

CARBOROD Ni3 is used for welding 3.5% nickel steels for low temperatures service, where weld metal toughness properties down to -101°C are required.

Classification	
EN ISO	636-B: W 55A 10 WN71
AWS	A5.28: ER 80S-Ni3

### Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Ni
0.08	0.8	0.5	≤0.010	≤0.010	3.5

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				-80 °C	-101 °C
As Welded	≥ 460	≥ 550	≥ 22	≥ 130	≥ 47








Gas test: 100% Ar

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

### Materials

ASTM A203 Grades D, E, F

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	●
2.0	TUB	5	●
2.4	TUB	5	●
3.2	TUB	5	●