



Elgomatic 162

GMAW - MIG MAG

Low-alloyed

Date: 2006-06-09
Revision: 5

Description:

Elgomatic 162 is a copper coated wire depositing a nominal 0.9% Ni weld metal. It has a guaranteed Ni content of 1% maximum, ensuring conformance to NACE requirements for oil and gas production equipment in sour service. The wire is primarily intended for GMAW but is equally suitable for use in mechanised GTAW eg. orbital TIG process (see Elgatic 162 for mechanical properties). Elgomatic 162 gives very good fracture toughness at temperatures down to -60°C and is intended for offshore pipework and similar high integrity applications.

Welding current:

DC+

Wire composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min	0,06	0,50	1,00				0,80
Typical	0,09	0,60	1,10	0,010	0,010		0,90
Max	0,12	0,80	1,25	0,020	0,020	0,15	0,99

	Mo	Cu	V	Al	Ti
Min					
Typical					
Max	0,15	0,35	0,03	0,02	0,15

Shielding gas:

Acc. to EN 439:

C1, 100% CO₂, 7-10 l/min.

M21, 80% Ar+20% CO₂, 7-10 l/min.

Chemical composition, wt.%

Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Re:	>460 N/mm ²	490 N/mm ²
Tensile Strength, Rm:	>530 N/mm ²	600 N/mm ²
Elongation, A5	>20%	26%
Impact energy, CV:	-60°C • >47 J	-60°C • 60 J

Classification:

EN 440 G3Ni1
AWS A5.28 ER80S-Ni1

Approvals:

Note

Typical values are based on M21.

Product data

Diam.mm	Product code	Dip Current A	Dip Voltage V	Spray Current A	Spray Voltage V
1,0	9735-2010	80-150	17-20	180-230	24-30