

# Pipelin<sup>®</sup>er 80Ni1

## TOP FEATURES

- Root pass capability up to X100 and hot, fill and cap pass up to X80 grade pipe
- Impact toughness capable of exceeding 69 - 95 J (51 - 70 ft·lb) at -50°C (-58°F)
- Q2 Lot<sup>®</sup> - Certificate showing actual deposit chemistry available online
- Excellent wire placement for narrow groove welding
- ProTech<sup>®</sup> packaging system

## TYPICAL APPLICATIONS

- Root pass welding on up to X100 grade pipe
- Hot, fill and cap pass welding on up to X80 grade pipe
- Pipeline
- Offshore

## CLASSIFICATION

AWS A5.28 ER80S-G  
EN ISO 14341-A G 3Ni1

## SHIELDING GASES (ACC. EN ISO 14175)

C1 Active gas 100% CO<sub>2</sub>  
M20/M21 Mixed gas 75-95% Ar/Balance CO<sub>2</sub>

## CHEMICAL COMPOSITION (WEIGHT %), TYPICAL WIRE

C	Mn	Si	P	S	Ni	Mo	Ti	Al
0.07	1.55	0.70	0.11	0.10	0.90	<0.01	0.08	<0.01

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)	
						-29°C	-50°C
Required: AWS A5.28				min. 550			
	C1	AW	600	665	28	80	45
	M20	AW	650	730	27	110	70

\* AW = As welded

## PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.0	SPOOL	4.5	ED033119
	SPOOL	15.0	ED033121
1.2	SPOOL	4.5	ED033122
	SPOOL	15.0	ED033120

### 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.