



## Nexus 2Ni

### 2 Ni wires for MIG and TIG welding low temperature steels

2%Ni Low alloy copper coated solid MIG/TIG wires for joining and overlaying materials of similar compositions at service temperatures down to - 50°C MIG (-70°C TIG).

#### International Standards

	BS EN 1668:1997 BS EN 440:1995	AWS A5.28- 05
TIG	W 42 5 2Ni2	ER80S-Ni2
MIG	G 42 5 2Ni2	ER80S-Ni2

#### Typical Wire Analysis (wt%)

C	Si	Mn	S	P	Ni
0.09	0.52	1.10	0.011	0.012	2.45

#### Typical All-Weld Metal Mechanical Properties

	Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation %	Impact Strength
TIG	≥430	≥540	≥22	≥47J @ -70°C
MIG	≥420	≥570	≥22	≥47J @ -50°C

#### Welding Positions

All Positions including vertical down
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#### Materials

S255N-S380N, 14Ni6, 12Ni14 and S255NL
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#### Packaging

Size mm	1.6	2.4	3.2
Plastic 5 kilo Tube	✓	✓	✓

Size mm	0.8	1.0	1.2
Metal spools 15 kilo	✓	✓	✓

#### Additional Information

Certification	BS EN 10204:2004 Type 3.1
Material safety data sheet	MSDS 11
BOC Shielding Gas MIG	Argoshield Light (<4mm) Universal (2-10mm) Heavy (>9mm)
BOC Shielding Gas TIG	Pureshield Argon