



# Elgatig 162

GTAW - TIG

Low-alloyed

Date:	2007-10-12
Revision:	6

## Description:

Elgatig 162 is a low alloy TIG rod 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. Elgatig 162 has very good fracture toughness at temperatures down to -60°C and is designed 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	0,01	0,01		0,90
Max	0,12	0,80	1,25	0,02	0,02	0,15	0,99

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

## Shielding gas:

I1, Argon, 7-10 l/min

## Stamping

F ER80S-Ni1

## Chemical composition, wt.%

## Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Re:	≥470 N/mm <sup>2</sup>	490 N/mm <sup>2</sup>
Tensile Strength, Rm:	≥550 N/mm <sup>2</sup>	600 N/mm <sup>2</sup>
Elongation, A5	≥24%	28%
Impact energy, CV:	-46°C • >27 J	-46°C • 90 J
	-60°C • >47 J	-60°C • 80 J

## Classification:

EN 1668

AWS A5.28

W 46 6 W3Ni1

ER80S-Ni1

## Approvals:

CE

## Product data

Diam.mm	Length mm	Product code
1,6	1000	9735-1016
2,0	1000	9735-1020
2,4	1000	9735-1024