


weathering resistant structural steels

WDI CuNi SG • VDG CuNi

Standard designation	DIN EN ISO 14341-A G3Ni1		AWS A 5.28 ER80 S-Ni1			
Properties and application range	Welding wire for MAG-welding of weathering resistant structural steels and special structural steels.					
Materials being suitable for welding	weathering resistant structural steels acc.to SEW 087 WTStE 37-2, WTStE 37-3, WTStE 52-3 special structural steels..... COR-TEN A, Patinax 37, CON-TEN B EN 10155..... S235J2W, S355J2G1W					
Reference analysis (%)	C 0,1	Si 0,8	Mn 1,4	Ni 0,7	Cu 0,3	
Mechanical performance according to EN 1597-1	post-weld heat treatment U U	inert gas C M2	yield strength N/mm ² 400 450	all-weld metal tensile strength N/mm ² 500 550	elongation (L ₀ =5d ₀) % 23 24	energy absorbed ISO-V(Joule) 55 80
Welding position						kind of current= + inert gas (EN 439) Argon mixed gas CO ²
Qualification tests and approvals	TÜV, DB					
Wire packaging	Spooling types see on pages 70-75 wire diameter 1,0 - 1,6 mm other dimensions on demand					