

ST-1N

Classification

AWS A5.28/ASME SFA-5.28 ER80S-Ni1

Features

- Impact value in low temp. is good
- Bead appearance & weldability are excellent

Current

DC -

Application Areas

- Oil & gas industry
- offshore industry
- Power plant, chemical industry

Shielding Gas

100% Ar

Approvals

ABS	BV	DNV	LR	RS	CWB
✓	✓	✓	✓	✓	✓

Typical Chemical Composition of the Wire (wt%)

C	Si	Mn	P	S	Cu	Ni	Cr	Fe
0.07	0.54	1.03	0.013	0.006	0.17	0.96	0.05	0.01

Typical Mechanical Properties of All-Weld Metal

Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
480 (70)	580 (84)	31	-50 (-50)	84 (62)

Wire Diameter & Packaging

Wire Diameter mm(in)	Packaging
1.6 (1/16)	5kg(11lbs)*1000
2.0 (5/64)	
2.4 (3/32)	
2.6 (0.10)	
3.2 (1/8)	

SMW

GMW

GTAW

FCW

Metal-cored Wire

SAW Wire

SAW Flux