



Elgatic 148K

GTAW - TIG

Low-alloyed

Date: 2013-05-27
Revision: 8

Description:

Elgatic 148K is a low-alloyed TIG-wire, which deposits a 2.4% Ni weld metal with good tensile strength and impact energy down to -60°C . It is intended for pipe welding of low alloyed steels in the offshore and shipbuilding industries.

Welding current:

DC-

Wire composition, wt.%

	C	Si	Mn	P	S	Ni	Cu
Min	0,06	0,4	0,98			2,10	
Typical	0,10	0,6	1,10	0,017	0,017	2,4	0,15
Max	0,12	0,8	1,25	0,025	0,025	2,70	0,35

Shielding gas:

I1, Argon, 7-10 l/min

Stamping

F Ni 2,5

Chemical composition, wt.%

	C	Si	Mn	Ni
Min				
Typical	0,08	0,45	1,15	2,2
Max				

Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Re:	$\geq 470 \text{ MPa}$	520 MPa
Tensile Strength, Rm:	$\geq 550 \text{ MPa}$	610 MPa
Elongation, A5	$\geq 24\%$	28%
Impact energy, CV:	$-62^{\circ}\text{C} \bullet 27 \text{ J}$ $-60^{\circ}\text{C} \bullet >47 \text{ J}$	$-60^{\circ}\text{C} \bullet 90 \text{ J}$

Classification:

EN 1668 W 46 6 W2Ni2
AWS A5.28 ER80S-Ni2

Approvals:

CE

Product data:

$\varnothing \times \text{Length mm}$	Packet weight	Product code
1,6 x 1000	5 kg	97401016
2,0 x 1000	5 kg	97401020
2,4 x 1000	5 kg	97401024