

**Specifications:**

AWS A5.28  
ASME SFA 5.28  
AWS ER80S-Ni1

**Properties:**

**Tensile Strength:** 87,000 psi min.  
**Yield Strength:** 73,950 psi min  
**Elongation:** 25% min.

**Description:**

WT 80S-Ni1 is a low alloy copper coated metal containing 1% nickel, allowing for welding of low temperature applications, as low as -50°F. The added nickel content increases the weathering resistance as well as improving the electrochemical balance of weld and base metal. PWHT is not required but preheat and interpass temperature is 300°F.

Available in multiple sizes and diameters.

**Chemical Composition (Wt%):**

Si	Mn	S	P	C	Cu	Mo	Ni	Cr	V
0.40-0.80	1.25	0.025	0.025	0.12	0.35	0.35	0.80-1.1	0.15	0.05

Note: Single values are maximum unless otherwise noted

Maintaining a proper welding procedure, including pre-heat and interpass temperatures, may be critical depending on the type and thickness of material being welded.

**CAUTION:** Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standards A49.1, "Safety in Welding and Cutting," published by the American Welding Society, 8669 NW 36 Street, #130, Miami, FL 33126: OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210.