

MT-2,5 Ni

MIG/TIG wire for welding fine grain steels and low alloyed low temperature steel. For working temperatures -60°C.

Standard designation

EN ISO 14341-A	G 46 6 M21 2 Ni 2
AWS/ASME SFA-5.28	ER 80 S-Ni 2

Main base metals

S255N-S380N, 14Ni6, 12Ni14, S255NL

Mechanical properties of all – weld – metal

Gas shield			M 21 untreated +20°C	M 21 untreated -60°C
Thermal treatment				
Test temperature		[°C]		
Yielding point	R _{eH}	MPa	>460	
Tensile strength	R _m	MPa	530-680	
Elongation	A ₅	[%]	>20	
Impact strength	A _V	[J]		>47

Average chemical composition of all-weld-metals

C	Si	Mn	Ni
0,03	0,4-0,8	0,8-1,4	2,1-2,7

Gas types applicable TIG
Gas types applicable MIG

I1
M 21

Approvals TIG
Approvals MIG

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TÜV, DB, CE

TIG rod diameters, unit weights

Diameter [mm]	Length [mm]	Kg per box
1,60	1000	25,0
2,00	1000	25,0
2,40	1000	25,0
3,20	1000	25,0

MIG welding wire

Diameter 0,8 mm 1,0 mm 1,2 mm

Welding positions MIG acc.to EN ISO 6947
Welding positions TIG acc.to EN ISO 6947

PA, PB, PC, PF
PA, PB, PC, PD, PE, PF

Current/Polarity TIG
Current/Polarity MIG

= -
= +