



Nexus 1Ni

1 Ni wires for MIG and TIG welding low temperature steels

0.9%Ni Low alloy copper coated solid MIG/TIG wires for joining and overlaying materials of similar compositions at service temperatures down to -40°C MIG (-50°C TIG).

International Standards

	BS EN 1668:1997 BS EN 440:1995	AWS A5.28- 05
TIG	W 46 5 3Ni1	ER80S-Ni1
MIG	G 46 4 3Ni1	ER80S-Ni1

Typical Wire Analysis (wt%)

C	Si	Mn	S	P	Ni
0.09	0.50	1.05	0.011	0.012	0.90

Typical All-Weld Metal Mechanical Properties

	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Impact Strength
TIG	≥470	≥560	≥24	≥47J@-50°C
MIG	≥470	≥560	≥24	≥47J@-40°C

Welding Positions

All Positions including vertical down

Materials

P355NL1, P460NL1

Packaging

Size mm	1.6	2.4	3.2
Plastic 5 kilo Tube	✓	✓	✓

Size mm	0.8	1.0	1.2
Metal spools 15 kilo	✓	✓	✓

Additional Information

Certification	BS EN 10204:2004 Type 3.1
Material safety data sheet	MSDS 11
BOC Shielding Gas MIG	Argoshield Light (<4mm) Universal (2-10mm) Heavy (>9mm)
BOC Shielding Gas TIG	Pureshield Argon