



## Nexus S3 1Ni 1/4Mo

### 1Ni<sup>1</sup>/<sub>4</sub>Mo TIG wire for welding high strength low alloy steels

Low alloy, copper coated solid TIG wire for joining high strength low alloy steels down to - 60°C.

#### International Standards

<b>AWS A5.28-96</b>
<b>ER90S-G</b>

#### Typical Wire Analysis (wt%)

<b>C</b>	<b>Si</b>	<b>Mn</b>	<b>S</b>	<b>P</b>	<b>Cr</b>	<b>Mo</b>
<b>0.10</b>	<b>0.21</b>	<b>1.54</b>	<b>0.008</b>	<b>0.007</b>	<b>0.81</b>	<b>0.25</b>

#### Typical All-Weld Metal Mechanical Properties

<b>Yield Strength N/mm<sup>2</sup></b>	<b>Tensile Strength N/mm<sup>2</sup></b>	<b>Elongation %</b>	<b>Impact Strength - 60°C</b>
<b>730</b>	<b>795</b>	<b>19</b>	<b>200</b>

#### Welding Positions

<b>All Positions including vertical down</b>
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#### Materials

<b>API 5LX 65,X70 pipe</b>
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#### Packaging

<b>Size mm</b>	<b>1.6</b>	<b>2.4</b>
<b>Plastic 5 kilo Tube</b>	<b>✓</b>	<b>✓</b>

#### Additional Information

<b>Certification</b>	<b>BS EN 10204:2004 Type 3.1</b>
<b>Material safety data sheet</b>	<b>MSDS 11</b>
<b>BOC Shielding Gas TIG</b>	<b>Pureshield Argon</b>