

# S-Ni2 X SA-08

## Conformances

ABS Manufacturer's Spec. (-196°C)  
 LR 9NiM  
 BV AN90M  
 DNV-GL VL1.5Ni up to VL9Ni  
 RS Manufacturer's Spec. (-196°C)

## Applications

- LNG storage tanks
- Liquid nitrogen storage tanks

## Features

- Dry the flux at 300~350°C for 60 minutes before use

## Welding Position

## Current

DC +

## Diameter / Packaging

| Diameter   | Spool        |
|------------|--------------|
| mm (in)    | 25kg (55lbs) |
| 2.0 (5/64) |              |
| 2.4 (3/32) | √            |
| 3.2 (1/8)  |              |

## Typical Chemical Composition of All-Weld Metal (%)

| C    | Si  | Mn  | P     | S     | Cr  | Ni   | Mo   | W   | Al  |
|------|-----|-----|-------|-------|-----|------|------|-----|-----|
| 0.04 | 0.2 | 0.5 | 0.001 | 0.001 | 2.0 | 66.0 | 19.0 | 2.5 | 0.2 |

## Typical Mechanical Properties of All-Weld Metal

| YS<br>MPa(lbs/in <sup>2</sup> ) | TS<br>MPa(lbs/in <sup>2</sup> ) | EL<br>(%) | Temp<br>°C(°F) | CVN-Impact Value<br>J (ft.lbs) |
|---------------------------------|---------------------------------|-----------|----------------|--------------------------------|
| 420 (61,000)                    | 680 (99,000)                    | 43.0      | -196 (-321)    | 100 (74)                       |

- Base Metal: 9% Ni

## Typical Welding Parameters

| Wire Feed Speed<br>m/min (in/min) | Amp.<br>(A) | Volt.<br>(V) |                 |
|-----------------------------------|-------------|--------------|-----------------|
| 2.4mm (3/32 in) DC+               |             |              |                 |
| 30~70                             | 300~380     | 24~28        | Horizontal Butt |