

Select 85-Ni3

Low Alloy / Gas Shielded / Flux Cored

PRODUCT DATA SHEET

FEATURES

- Features a basic slag system capable of producing low oxygen welds with excellent mechanical properties at very low temperatures (-100 F)
- Globular bead transfer and slightly convex beads, typical of basic slag systems
- Applications include shipbuilding, and tanks used for gas storage

CONFORMANCES

AWS A5.29

E80T5-Ni3M-H4

DIAMETERS (in [mm])

0.045 (1.2), 1/16 (1.6), 3/32 (2.4)

POSITIONS



SHIELDING GAS

75-80% Ar / Balance CO2

Flow Rate: 40 - 50 CFH

POLARITY

Direct Current Electrode Positive (DCEP)

TYPICAL WELD DEPOSIT CHEMISTRY [WT%]

Shielding Gas	C	Mn	Ni	P	S	Si
75%Ar / 25%CO2	0.06	1.45	3.48	0.004	0.011	0.19

TYPICAL MECHANICAL PROPERTIES

Shielding Gas	Tensile Strength ksi (MPa)	Yield Strength ksi (MPa)	Elongation (%)	Weld Condition	PWHT Temp	CVN @ -100°F (-73°C) ft-lb (J)
75%Ar / 25%CO2	90 (621)	75 (517)	23	PWHT	1150°F for 1 hr	38 (52)



Revision: 1/17/2025

Notice: Be sure to follow all your employers safety practices, policies and procedures when using this product. Refer to CSA W117.2 and ANSI Z49.1 Safety in Welding, Cutting and Allied Processes for further information and the manufactures SDS sheet. The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for use in the field. The manufacturer disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.

600 Enterprise Drive, P.O. Box 259, Fort Loramie, Ohio 45845-0259 • 800-341-5215 • www.Select-Arc.com

RECOMMENDED WELDING PARAMETERS **

Diameter in (mm)	Shielding Gas	Position	WFS* in/min (m/min)	Amps	Volts	CTWD* in (mm)
0.045 (1.2 mm)	75% Ar/25% CO2	Flat & Horizontal	275 (7.0)	160	24	5/8 (16)
		Flat & Horizontal	350 (8.9)	190	26	5/8 - 3/4 (16 - 19)
		Flat & Horizontal	435 (11.0)	220	28	5/8 - 3/4 (16 - 19)
1/16 (1.6 mm)	75% Ar/25% CO2	Flat & Horizontal	250 (6.4)	265	24	3/4 (19)
		Flat & Horizontal	280 (7.1)	290	26	3/4 - 1 (19 - 25)
		Flat & Horizontal	315 (8.0)	315	28	3/4 - 1 (19 - 25)
3/32 (2.4 mm)	75% Ar/25% CO2	Flat & Horizontal	145 (3.7)	320	24	1 1/4 (32)
		Flat & Horizontal	160 (4.1)	345	26	1 1/4 - 1 1/2 (32 - 38)
		Flat & Horizontal	170 (4.3)	370	28	1 1/4 - 1 1/2 (32 - 38)

* WFS = Wire Feed Speed, CTWD = Contact Tip To Work Distance

**The parameters listed are recommended starting points of operation and the ranges for amperage, wfs, and voltage could be extended based on fitness for application. For products with "all-position" capability, as determined and listed in classification, the position recommendation can be determined based on operator skill and material thickness and isn't limited to the listing.

PACKAGING (lbs [kgs])

33 (15) Spools, 60 (27.2) Coils, 500 (226.8) Round Drum, 800 (362.9) Hex Drum, 900 (408.2) Hex Drum

*Some packaging options may not be available depending on diameter and product. Special package options may be available upon request.

STORAGE AND HANDLING

All products should be stored in original packaging, in dry conditions and handled with care. For more information refer to our website.



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