



CEWELD SG 3 Tig

TYPE	Copper coated welding wire for GTAW welding of un and -low alloyed steels																								
ANWENDUNGEN	Shipbuilding, piping, root welding, bridges, repair, construction, offshore, car-plate welding etc...																								
EIGENSCHAFTEN	Extreme easy to weld with excellent welding properties and increased yield strenght.																								
KLASSIFIKATION	AWS	A 5.18: ER 70S-6																							
	EN ISO	636-A: W 50 5 4 Si1																							
	W.Nr.	1.5130																							
	F-nr	6																							
	FM	1																							
GEEIGNET FÜR	<p>Reh ≤ 460 MPa (67 ksi) ISO 15608: 1.2, 1.3, 2.1 1.5637, 1.6217, 1.6228, 1.0044-1.09821.0035 - 1.0570, 1.0345, 1.0425, 1.0481, 1.0308 - 1.0581, 1.0307 - 1.0582, 1.0440, 1.0472, 1.0475, 1.0416 to 1.0551 10Ni14, 12Ni14, 13MnNi6-3, 15NiMn6, S235JR-S355JR, S235JO-S355JO, S450JO, S235J2-S355J2, S275N-S460N, S275M-S460M, P235GH-P355GH, P275NL1-P460NL1, P215NL, P265NL, P355N, P285NH-P460NH, P195TR1-P265TR1, P195TR2-P265TR2, P195GH-P265GH, L245NB-L415NB, L450QB, L245MB-L450MB, GE200-GE240, A, B, D, E, A 32-E 36 ASTM A 106 Gr. A, B, C; A 181 Gr. 60, 70; A 283 Gr. A, C; A 285 Gr. A, B, C; A 350 Gr. LF1; A 414 Gr. A, B, C, D, E, F, G; A 501 Gr. B; A 513 Gr. 1018; A 516 Gr. 55, 60, 65, 70; A 573 Gr. 58, 65, 70; A 588 Gr. A, B; A 633 Gr. C, E; A 662 Gr. B; A 711 Gr. 1013; A 841 Gr. A; API 5 L Gr. B, X42, X52, X56, X60, X65 Domex 315-460MC, MC Plus, ML</p>																								
ZULASSUNGEN	TÜV: 12399.00, CE																								
SCHWEISSPOSITIONEN																									
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>V</th> <th>Cu</th> <th>Al</th> <th>Ti+Zr</th> </tr> </thead> <tbody> <tr> <td>0.08</td> <td>0.95</td> <td>1.75</td> <td>0.012</td> <td>0.015</td> <td>0.01</td> <td>0.01</td> <td>0.01</td> <td>0.001</td> <td>0.009</td> <td>0.002</td> <td>0.013</td> </tr> </tbody> </table>	C	Si	Mn	P	S	Cr	Ni	Mo	V	Cu	Al	Ti+Zr	0.08	0.95	1.75	0.012	0.015	0.01	0.01	0.01	0.001	0.009	0.002	0.013
C	Si	Mn	P	S	Cr	Ni	Mo	V	Cu	Al	Ti+Zr														
0.08	0.95	1.75	0.012	0.015	0.01	0.01	0.01	0.001	0.009	0.002	0.013														
MECHANISCHE GÜTEWERTE	<table border="1"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R_{P0,2} (MPa)</th> <th rowspan="2">R_m (MPa)</th> <th rowspan="2">A₅ (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th>-20°C</th> <th>-40°C</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>520</td> <td>600</td> <td>24</td> <td>170</td> <td>110</td> <td>HRC</td> </tr> </tbody> </table>	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness	-20°C	-40°C	As Welded	520	600	24	170	110	HRC								
Heat Treatment	R _{P0,2} (MPa)					R _m (MPa)	A ₅ (%)		Impact Energy (J) ISO-V		Hardness														
		-20°C	-40°C																						
As Welded	520	600	24	170	110	HRC																			
RÜCKTROCKNUNG	Not required																								
GAS ACC. EN ISO 14175	I1																								



CEWELD SG 3 Tig

SG 3 TIG 1,6 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663405234

SG 3 TIG 2,0 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663405241

SG 3 TIG 2,4 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663405258

SG 3 TIG 3,0 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663405265

SG 3 TIG 3,2 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663405272