



CEWELD G3

TYPE Copper-coated filler metal for gas welding (0,5% Ni)

APPLICATIONS Gas welding of steels that require good impact properties at low temperature.

PROPERTIES Excellent impact properties at low temperatures due to the addition of Nickel with increased yield strenght.

CLASSIFICATION

AWS	A 5.2: R60
EN ISO	20378: O III
F-nr	6
FM	1

SUITABLE FOR Steels up to a yield strength of 275MPa (40 ksi). S185-E295, S235JR-S275JR ASTM: A36, A106 grades A/B/C, A139 grade A, A210 grades A1/C, A216 grades WCA/WCB/WCC, A234 grade WPB

APPROVALS CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	Ni
0.1	0.1	1.1	0.4

MECHANICAL PROPERTIES

Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				RT		
As Welded	340	470	20	65		HRc

REDRYING Not required

GAS ACC. EN ISO 14175 None