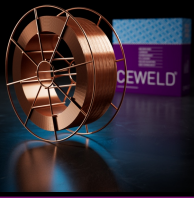




CEWELD SG Ni2,5

TYPE	Solid welding wire for extra low temperature applications.							
APPLICATIONS	This Filler metal was developed for fine-grain steels and low-temperature steels. Typical applications are welding boilers for liquid petrol gas (LPG)							
PROPERTIES	He is a copper coated, Ni-alloyed (2,4% Ni), solid wire for low temperature steels in applications such as vessels, pipes and in the offshore industry with a minimum yield strength of 470 Mpa. The wire provides excellent impact toughness down to -60°C.							
CLASSIFICATION	AWS	A 5.28: ER 80S-Ni2						
	EN ISO	14341-A: G 46 6 M21 2Ni2						
	F-nr	6						
	FM	1						
SUITABLE FOR	For cryogenic construction steels and Ni bearing low temperature steels. 11MnNi5-3, 13MnNi6-3, 15NiMn6, S275NL-S460NL, S275ML-S460ML, P275NL2-P460NL2, P355ML2-P460ML2 ASTM: A203 grade A/B, A333/A334 grades 1/6/7, A350 grade LF2/LF5/LF6, A352 grade LC1/LC2							
APPROVALS	CE							
WELDING POSITIONS								
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	P	S	Ni		
	0.1	0.5	1.1	0.015	0.015	2.5		
MECHANICAL PROPERTIES	Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness
	As Welded	540	630	28	-40°C	-60°C	-70°C	HRc
					100	60	47	
REDRYING	Not required							
GAS ACC. EN ISO 14175	M21							



CEWELD SG Ni2,5

SG NI2,5 0,8MM

Packaging	KG/unit	EanCode
BS-300	15	8720663405746

SG NI2,5 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663405753

SG NI2,5 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663405760

SG NI2,5 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663405777