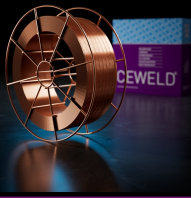


# CEWELD SG 3

TYPE	Copper coated welding wire for MAG welding of un and -low alloyed steels																
APPLICATIONS	Shipbuilding, piping, root welding, bridges, repair, construction, offshore, car-plate welding etc...																
PROPERTIES	Extreme easy to weld with excellent welding properties and increased yield strength. High world wide excepted quality with controlled cast and helix for semi and or semi-automatic applications. Weldable with CO2 and Mix gas.																
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.18: ER 70S-6</td> </tr> <tr> <td>EN ISO</td> <td>14341-A: G 42 4 C1 4Si1</td> </tr> <tr> <td>W.Nr.</td> <td>1.5130</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>1</td> </tr> </table>	AWS	A 5.18: ER 70S-6	EN ISO	14341-A: G 42 4 C1 4Si1	W.Nr.	1.5130	F-nr	6	FM	1						
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EN ISO	14341-A: G 42 4 C1 4Si1																
W.Nr.	1.5130																
F-nr	6																
FM	1																
SUITABLE FOR	<p><b>Reh ≤ 460 MPa (67 ksi) ISO 15608: 1.2, 1.3, 2.1 ( Mix gas )</b></p> <p>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</p> <p>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>																
APPROVALS	TÜV: 12399.00, CE, DB: 42.206.02																
WELDING POSITIONS																	
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> </tr> </thead> <tbody> <tr> <td>0.08</td> <td>0.9</td> <td>1.75</td> <td>0.015</td> <td>0.015</td> </tr> </tbody> </table>	C	Si	Mn	P	S	0.08	0.9	1.75	0.015	0.015						
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MECHANICAL PROPERTIES	<table border="1"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R<sub>p0,2</sub> (MPa)</th> <th rowspan="2">R<sub>m</sub> (MPa)</th> <th rowspan="2">A<sub>5</sub> (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th>RT</th> <th>-40°C</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>490</td> <td>620</td> <td>26</td> <td>170</td> <td>110</td> <td>HRc</td> </tr> </tbody> </table>	Heat Treatment	R <sub>p0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness	RT	-40°C	As Welded	490	620	26	170	110	HRc
Heat Treatment	R <sub>p0,2</sub> (MPa)					R <sub>m</sub> (MPa)	A <sub>5</sub> (%)		Impact Energy (J) ISO-V		Hardness						
		RT	-40°C														
As Welded	490	620	26	170	110	HRc											
REDRYING	Not required																
GAS ACC. EN ISO 14175	M21, C1																



# CEWELD SG 3

## SG 3 0,8MM

Packaging	KG/unit	EanCode
BS-300	15	8720663405210
D-200	5	8720663405050
Drum	250	8720663405227

## SG 3 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663405203
D-100	1	8720663405289
D-200	5	8720663405296
Drum	250	8720663405302

## SG 3 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663405104
Drum	250	8720663405111

## SG 3 1,4MM

Packaging	KG/unit	EanCode
Drum	250	8720663405128

## SG 3 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663405098