



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)																								
PROPRIÉTÉS	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																							
CONVIENT POUR	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																								
AGRÉMENTS	CE																								
POSITIONS DE SOUDAGE																									
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>Ni</th> </tr> </thead> <tbody> <tr> <td>0.1</td> <td>0.5</td> <td>1.1</td> <td>0.015</td> <td>0.015</td> <td>2.5</td> </tr> </tbody> </table>					C	Si	Mn	P	S	Ni	0.1	0.5	1.1	0.015	0.015	2.5								
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PROPRIÉTÉS MÉCANIQUES	<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="3">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th>-40°C</th> <th>-60°C</th> <th>-70°C</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>540</td> <td>630</td> <td>28</td> <td>100</td> <td>60</td> <td>47</td> <td>HRc</td> </tr> </tbody> </table>						Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness	-40°C	-60°C	-70°C	As Welded	540	630	28	100	60	47	HRc
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				-40°C	-60°C	-70°C																			
As Welded	540	630	28	100	60	47	HRc																		
ETUVAGE	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