



# CEWELD SG Ni1

<b>TYPE</b>	Filler metal for fine grain steels and cold-tough steels.		
<b>APPLICATIONS</b>	Offshore requirements at working temperatures down to -60 °C such as crane, vessel, rigs, platforms, pipelines for NACE requirements, boiler, tubing etc.		
<b>PROPRIÉTÉS</b>	Excellent impact properties at low temperatures due to the addition of Nickel and increased yield strenght above 460 MPa.		
<b>CLASSIFICATION</b>	AWS	A 5.28: ER 80S-Ni1	
	EN ISO	14341-A: G 50 6 M21 3Ni1	
	F-nr	6	
	FM	1	

<b>CONVIENT POUR</b>	<b>Materials</b>	<b>DIN</b>	<b>EN</b>	<b>ASTM</b>
	shipbuilding	A, B, D, E, AH 32 - EH 36	same	Typical
	Unalloyed steels	St 33, St 37-2 - St 52-3	S185 - S355-S460	A 258 / A 516
	boiler steels	H I, H III, 17Mn4, 19Mn5	P235GH, P355GH	A 662 / A 387
	pipe steels	St 35.8, St 45.8	P235T1/T2, P460NL2	A 738 / A 612
	-	StE 210.7 TM, StE 480.7 TM	L210 - L480MB	A 299
	Fine grain steels	StE 255 to StE 460	S255 - S500 (NL1,2)	-
	API-standard	X 42, X65	X 42, X65	-

**AGRÉMENTS** CE

**POSITIONS DE SOUDAGE**



**TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)**

C	Si	Mn	Ni
0.08	0.5	1.1	0.9

**PROPRIÉTÉS MÉCANIQUES**

Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
				-40°C	-60°C	
As Welded	510	580	22	70	50	HRc
620°C±15°C 2h	430	540	31	110	HRc	

**ETUVAGE** Not required

**GAS ACC. EN ISO 14175** M21



# CEWELD SG Ni1

SG Ni1 0,8MM

Packaging	KG/unit	EanCode
BS-300	15	8720663405685

SG Ni1 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663405678

SG Ni1 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663416728