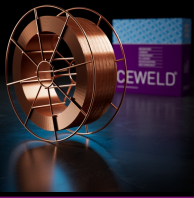


CEWELD SG 1

TYPE	Fil de soudure cuivré SG1 (ER 70S3)																
APPLICATIONS	Construction navale, offshore, réparation, construction, soudage de tôles de voitures, etc...																
PROPRIÉTÉS	Extrêmement facile à souder avec d'excellentes propriétés de soudage. Convient au soudage de tôles galvanisées ou de dépôts de soudure qui doivent être galvanisés par la suite en raison de la faible teneur en silicium. Qualité élevée reconnue dans le monde entier avec une coulée et une hélice contrôlées pour les applications semi-automatiques ou semi-automatiques. Soudable au gaz Co2 et Mix.																
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.18: ER 70S-3</td> </tr> <tr> <td>EN ISO</td> <td>14341-A: G 42 4 M21 2Si</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-3	EN ISO	14341-A: G 42 4 M21 2Si	F-nr	6	FM	1								
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EN ISO	14341-A: G 42 4 M21 2Si																
F-nr	6																
FM	1																
CONVIENT POUR	<p>Rp < 420 MPa (60ksi) ISO 15608: 1.1 ReH < 275 MPa, 1.2 275 < ReH < 360 MPa , (1.3 ReH > 360 MPa < 420 MPa)</p> <p>1.0035, 1.0038, 1.0039, 1.0044, 1.0112, 1.0116, 1.0130, 1.0145, 1.0253, 1.0254, 1.0255, 1.0258, 1.0259, 1.0319, 1.0345, 1.0345, 1.0345, 1.0348, 1.0352, 1.0418, 1.0420, 1.0425, 1.0425, 1.0425, 1.0451, 1.0452, 1.0453, 1.0457, 1.0459, 1.0460, 1.0460, 1.0461, 1.0486, 1.0490, 1.0491, 1.0619, 1.1100, 1.0409, 1.0421, 1.0426, 1.0429, 1.0430, 1.0436, 1.0473, 1.0481, 1.0482, 1.0484, 1.0505, 1.0545, 1.0546, 1.0562, 1.0566, 1.0570, 1.0578, 1.0581, 1.0582, 1.8902, 1.8912, 1.8932</p> <p>S235JR-S355JR, S235JO-S355JO, P195TR1-P265TR1, P195GH-P265GH, L245NB-L360NB, L245MB-L360MB, L415NB, L415MB, WStE 380, WStE 420, S420NL</p> <p>A, B, D</p> <p>ASTM A 106, Gr. A, B; A 283 Gr. A, C; A 285 Gr. A, B, C; A 501, Gr. B; A 573, Gr. 58, 65, 70; A 633, Gr. A, C; A 711 Gr. 1013; API 5 L Gr. B, X42, X52, X60</p>																
AGRÉMENTS	CE																
POSITIONS DE SOUDAGE																	
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td style="width: 33%;">C</td> <td style="width: 33%;">Si</td> <td style="width: 33%;">Mn</td> </tr> <tr> <td>0.07</td> <td>0.5</td> <td>1.3</td> </tr> </table>	C	Si	Mn	0.07	0.5	1.3										
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PROPRIÉTÉS MÉCANIQUES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">Rp0,2 (MPa)</th> <th rowspan="2">Rm (MPa)</th> <th rowspan="2">A5 (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th colspan="2">-40°C</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>467</td> <td>553</td> <td>26</td> <td colspan="2">110</td> <td>HRc</td> </tr> </tbody> </table>	Heat Treatment	Rp0,2 (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness	-40°C		As Welded	467	553	26	110		HRc
Heat Treatment	Rp0,2 (MPa)					Rm (MPa)	A5 (%)		Impact Energy (J) ISO-V		Hardness						
		-40°C															
As Welded	467	553	26	110		HRc											
ETUVAGE	Non requis																
GAS ACC. EN ISO 14175	M20, M21, C1																



CEWELD SG 1

SG 1 0,8MM

Packaging	KG/unit	EanCode
D-100	1	8720663404817
D-300	15	8720663404824

SG 1 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663404848
D-100	1	8720663404831
Drum	250	8720663404855

SG 1 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663404862
Drum	250	8720663404879

SG 1 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663404886