



CEWELD SG 1 Tig

TYPE	Verkoperde lasdraad voor TIG lassen van on- en laaggelegeerd staal met een laag silicium- en mangaangehalte																								
TOEPASSINGEN	Scheepsbouw, offshore, reparatie, constructie, auto-plaat lassen enz...																								
EIGENSCHAPPEN	Extreem gemakkelijk te lassen met uitstekende laseigenschappen, geschikt voor het lassen van gegalvaniseerde platen of lasnaden die achteraf gegalvaniseerd moeten worden vanwege het lage siliciumgehalte.																								
CLASSIFICATIE	<table border="0"> <tr> <td>AWS</td> <td>A 5.18: ER 70S-3</td> </tr> <tr> <td>EN ISO</td> <td>636-A: W 42 2 W2Si</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	636-A: W 42 2 W2Si	F-nr	6	FM	1																
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GESCHIKT VOOR	St 33 – St 52 ,A, E, AH, EH ,HI-HIII, 17Mn4, St 37.0/4 – St 52.0/4, StE 255 – StE 420																								
GOEDKEURINGEN	CE																								
LASPOSITIES																									
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>Cr</th> <th>Ni</th> <th>Mo</th> <th>V</th> <th>Cu</th> <th>Al</th> <th>Ti+Zr</th> </tr> </thead> <tbody> <tr> <td>0.08</td> <td>0.6</td> <td>1.1</td> <td>0.009</td> <td>0.014</td> <td>0.06</td> <td>0.03</td> <td>0.01</td> <td>0.003</td> <td>0.03</td> <td>0.003</td> <td>0.012</td> </tr> </tbody> </table>	C	Si	Mn	P	S	Cr	Ni	Mo	V	Cu	Al	Ti+Zr	0.08	0.6	1.1	0.009	0.014	0.06	0.03	0.01	0.003	0.03	0.003	0.012
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MECHANISCHE WAARDEN	<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="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th colspan="2">-20°C</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>470</td> <td>560</td> <td>30</td> <td colspan="2">100</td> <td>HRC</td> </tr> </tbody> </table>	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness	-20°C		As Welded	470	560	30	100		HRC								
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HERDROGEN	Not required																								
GAS ACC. EN ISO 14175	I1																								



CEWELD SG 1 Tig

SG 1 TIG 1,6 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663411198

SG 1 TIG 2,0 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663411204

SG 1 TIG 2,4 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663411211

SG 1 TIG 3,0 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663411273

SG 1 TIG 3,2 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663411228