



# CEWELD SG 1 Tig

**TYPE** Copper coated welding wire developed for Tig welding of un and -low alloyed steels with low silicon and manganese content.

**ANWENDUNGEN** Shipbuilding, offshore, repair, construction, car-plate welding etc...

**EIGENSCHAFTEN** Extreme easy to weld with excellent welding properties suitable for welding galvanized plates or weld deposits that have to be galvanized afterwards due to the low silicon content.

**KLASSIFIKATION**

AWS	A 5.18: ER 70S-3
EN ISO	636-A: W 42 2 W2Si
F-nr	6
FM	1

**GEEIGNET FÜR** St 33 – St 52 ,A, E, AH, EH ,HI-HIII, 17Mn4, St 37.0/4 – St 52.0/4, StE 255 – StE 420

**ZULASSUNGEN** CE

**SCHWEISSPOSITIONEN**



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

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

**MECHANISCHE GÜTEWERTE**

Heat Treatment	R <sub>P0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
				-20°C		
As Welded	470	560	30	100		HRc

**RÜCKTROCKNUNG** Not required

**GAS ACC. EN ISO 14175** 11



# 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