




CEWELD SG Ni2,5

TYPE	Solid welding wire for extra low temperature applications.																			
ANWENDUNGEN	This Filler metal was developed for fine-grain steels and low-temperature steels. Typical applications are welding boilers for liquid petrol gas (LPG)																			
EIGENSCHAFTEN	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.																			
KLASSIFIKATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.28: ER 80S-Ni2</td> </tr> <tr> <td>EN ISO</td> <td>14341-A: G 46 6 M21 2Ni2</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>1</td> </tr> </table>	AWS	A 5.28: ER 80S-Ni2	EN ISO	14341-A: G 46 6 M21 2Ni2	F-nr	6	FM	1											
AWS	A 5.28: ER 80S-Ni2																			
EN ISO	14341-A: G 46 6 M21 2Ni2																			
F-nr	6																			
FM	1																			
GEEIGNET FÜR	<p>For cryogenic construction steels and Ni bearing low temperature steels.</p> <p>11MnNi5-3, 13MnNi6-3, 15NiMn6, S275NL-S460NL, S275ML-S460ML, P275NL2-P460NL2, P355ML2-P460ML2</p> <p>ASTM: A203 grade A/B, A333/A334 grades 1/6/7, A350 grade LF2/LF5/LF6, A352 grade LC1/LC2</p>																			
ZULASSUNGEN	CE																			
SCHWEISSPOSITIONEN																				
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <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							
C	Si	Mn	P	S	Ni															
0.1	0.5	1.1	0.015	0.015	2.5															
MECHANISCHE GÜTEWERTE	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <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
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													
RÜCKTROCKNUNG	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