



CEWELD SG Ni3,5

TYPE	Solid MIG wire for extra low temperature applications.						
ANWENDUNGEN	Used in petrochemical industry where it finds applications in construction of cryogenic plant and associated pipework, in the manufacture, storage and distribution of volatile liquids and liquefied gases.						
EIGENSCHAFTEN	Excelent impact properties at subzero temperatures down to -80°C.						
KLASSIFIKATION	AWS	A 5.28: ER 80S-Ni3					
	EN ISO	14341-B: G 57P 7 M22 SN71					
	F-nr	6					
	FM	1					
GEEIGNET FÜR	ASTM	A 203 Gr D, E, F - A 333 Gr 3 - A 350 Gr LF3 - A 352 Gr LC3					
	EN	(BS 1501 Gr 503 - BS 1503 Gr 503 - BS 1504 Gr 503 LT60)					
ZULASSUNGEN	CE						
SCHWEISSPOSITIONEN							
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	P	S	Ni	Cu
	0.1	0.6	1	0.01	0.01	3.5	0.12
MECHANISCHE GÜTEWERTE	Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
	620°C±15°C 2h	>550	>630	>25	-70°C		HRc
					40		
RÜCKTROCKNUNG	Not required						
GAS ACC. EN ISO 14175							