



CEWELD SG 3 Tig

TYPE	Copper coated welding wire for GTAW welding of un and -low alloyed steels											
APPLICATIONS	CEWELD® SG 3 Tig can be used universally in tank, boiler and general steel construction as well as in shipbuilding and pipeline construction, especially for root welding. Also suitable for sour gas applications due to its very low P/S/Ni content.											
PROPERTIES	CEWELD® SG 3 Tig is extreme easy to weld with excellent welding properties and increased yield strength.											
CLASSIFICATION	AWS	A 5.18: ER 70S-6										
	EN ISO	636-A: W 50 5 4 Si1										
	W.Nr.	1.5130										
	F-nr	6										
	FM	1										
SUITABLE FOR	Reh ≤ 460 MPa (67 ksi) ISO 15608: 1.2, 1.3, 2.1 1.5637, 1.6217, 1.6228, 1.0044-1.09821.0035 - 1.0570, 1.0345, 1.0425, 1.0481, 1.0308 - 1.0581, 1.0307 - 1.0582, 1.0440, 1.0472, 1.0475, 1.0416 to 1.0551 10Ni14, 12Ni14, 13MnNi6-3, 15NiMn6, S235JR-S355JR, S235JO-S355JO, S450JO, S235J2-S355J2, S275N-S460N, S275M-S460M, P235GH-P355GH, P275NL1-P460NL1, P215NL, P265NL, P355N, P285NH-P460NH, P195TR1-P265TR1, P195TR2-P265TR2, P195GH-P265GH, L245NB-L415NB, L450QB, L245MB-L450MB, GE200-GE240, A, B, D, E, A 32-E 36 ASTM A 106 Gr. A, B, C; A 181 Gr. 60, 70; A 283 Gr. A, C; A 285 Gr. A, B, C; A 350 Gr. LF1; A 414 Gr. A, B, C, D, E, F, G; A 501 Gr. B; A 513 Gr. 1018; A 516 Gr. 55, 60, 65, 70; A 573 Gr. 58, 65, 70; A 588 Gr. A, B; A 633 Gr. C, E; A 662 Gr. B; A 711 Gr. 1013; A 841 Gr. A; API 5 L Gr. B, X42, X52, X56, X60, X65 Domex 315-460MC,MC Plus, ML											
APPROVALS	CE											
WELDING POSITIONS												
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	P	S	Cr	Ni	Mo	V	Cu	Al	Ti+Zr
	0.08	0.95	1.75	0.012	0.015	0.01	0.01	0.01	0.001	0.009	0.002	0.013
MECHANICAL PROPERTIES	Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V						Hardness	
					-20°C		-40°C					
	As Welded	520	600	24	170		110				HRc	
REDRYING	Not required											
GAS ACC. EN ISO 14175	I1											



CEWELD SG 3 Tig

SG 3 TIG 1,6 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663405234

SG 3 TIG 2,0 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663405241

SG 3 TIG 2,4 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663405258

SG 3 TIG 3,0 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663405265

SG 3 TIG 3,2 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663405272