



# CEWELD SG Ni2,5 Tig

**TYPE** Solid welding wire for extra low temperature applications.

**APPLICATIONS** Filler metal developed for fine grain steels and cold-tough steels. Typical applications are welding boilers for liquid petrol gas (LPG)

**PROPERTIES** 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.

**CLASSIFICATION**

AWS	A 5.28: ER 80S-Ni2
EN ISO	636-A: W 42 9 2Ni2
F-nr	6
FM	1

**SUITABLE FOR** For cryogenic construction steels and Ni bearing low temperature steels.

11MnNi5-3, 13MnNi6-3, 15NiMn6, S275NL-S460NL, S275ML-S460ML, P275NL2-P460NL2, P355ML2-P460ML2  
 ASTM: A203 grade A/B, A333/A334 grades 1/6/7, A350 grade LF2/LF5/LF6, A352 grade LC1/LC2

**APPROVALS** CE

**WELDING POSITIONS**



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

C	Si	Mn	Ni
0.1	0.5	1.05	2.45

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>P0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness
				-40°C	-60°C	-80°C	
As Welded	540	630	28	100	60	47	HRc

**REDRYING** Not required

**GAS ACC. EN ISO 14175** I1



# CEWELD SG Ni2,5 Tig

SG NI2,5 TIG 1,6 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663405784
SG NI2,5 TIG 2,0 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663405791
SG NI2,5 TIG 2,4 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663405807
SG NI2,5 TIG 3,2 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663405814