



CEWELD SG Ni1 Tig

TYPE	Filler metal for fine grain steels and cold-tough steels.	
APPLICATIONS	Offshore requirements at working temperatures down to -60° C such as crane, vessel, rigs, platforms, pipelines for NACE requirements, boiler, tubing etc.	
PROPERTIES	Excellent impact properties at low temperatures due to the addition of Nickel and increased yield strength above 460 MPa.	
CLASSIFICATION	AWS	A 5.28: ER 80S-Ni1
	EN ISO	636-A: W 46 6 3Ni
	F-nr	6
	FM	1

SUITABLE FOR	Materials	DIN	EN	ASTM
	shipbuilding	A, B, D, E, AH 32 - EH 36	same	Typical
	Unalloyed steels	St 33, St 37-2 - St 52-3	S185 - S355-S460	A 258 / A 516
	boiler steels	H I, H III, 17Mn4, 19Mn5	P235GH, P355GH	A 662 / A 387
	pipe steels	St 35.8, St 45.8	P235T1/T2, P460NL2	A 738 / A 612
	-	StE 210.7 TM, StE 480.7 TM	L210 - L480MB	A 299
	Fine grain steels	StE 255 to StE 460	S255 - S500 (NL1,2)	-
API-standard	X 42, X65	X 42, X65	-	

APPROVALS CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

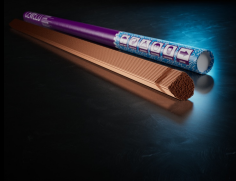
C	Si	Mn	P	S	Ni
0.08	0.5	1.05	0.007	0.015	0.9

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				-40°C	-60°C	
As Welded	500	570	24	70	55	HRc

REDRYING Not required

GAS ACC. EN ISO 14175 I1



CEWELD SG Ni1 Tig

SG NI1 TIG 1,6 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663405692
SG NI1 TIG 2,0 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663405708
SG NI1 TIG 2,4 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663405722
SG NI1 TIG 3,2 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663405739