



# CEWELD SG 1 Tig

TYPE	Verkoperde lasdraad voor TIG lassen van on- en laaggelegeerd staal met een laag silicium- en mangaangehalte																																			
TOEPASSINGEN	Scheepsbouw, offshore, reparatie, constructie, auto-plaat lassen enz...																																			
EIGENSCHAPPEN	Extreem gemakkelijk te lassen met uitstekende laseigenschappen, geschikt voor het lassen van gegalvaniseerde platen of lasnaden die achteraf gegalvaniseerd moeten worden vanwege het lage siliciumgehalte.																																			
CLASSIFICATIE	AWS	A 5.18: ER 70S-3																																		
	EN ISO	636-A: W 42 2 W2Si																																		
	F-nr	6																																		
	FM	1																																		
GESCHIKT VOOR	St 33 – St 52 ,A, E, AH, EH ,HI-HIII, 17Mn4, St 37.0/4 – St 52.0/4, StE 255 – StE 420																																			
GOEDKEURINGEN	CE																																			
LASPOSITIES																																				
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>Cr</th> <th>Ni</th> <th>Mo</th> <th>V</th> <th>Cu</th> <th>Al</th> <th>Ti+Zr</th> </tr> </thead> <tbody> <tr> <td>0.08</td> <td>0.6</td> <td>1.1</td> <td>0.009</td> <td>0.014</td> <td>0.06</td> <td>0.03</td> <td>0.01</td> <td>0.003</td> <td>0.03</td> <td>0.003</td> <td>0.012</td> </tr> </tbody> </table>												C	Si	Mn	P	S	Cr	Ni	Mo	V	Cu	Al	Ti+Zr	0.08	0.6	1.1	0.009	0.014	0.06	0.03	0.01	0.003	0.03	0.003	0.012
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MECHANISCHE WAARDEN	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R<sub>P0,2</sub> (MPa)</th> <th rowspan="2">R<sub>m</sub> (MPa)</th> <th rowspan="2">A<sub>5</sub> (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th colspan="2">-20°C</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>470</td> <td>560</td> <td>30</td> <td colspan="2">100</td> <td>HRC</td> </tr> </tbody> </table>												Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness	-20°C		As Welded	470	560	30	100		HRC								
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As Welded	470	560	30	100		HRC																														
HERDROGEN	Not required																																			
GAS ACC. EN ISO 14175	I1																																			



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SG 1 TIG 1,6 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663411198

SG 1 TIG 2,0 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663411204

SG 1 TIG 2,4 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663411211

SG 1 TIG 3,0 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663411273

SG 1 TIG 3,2 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663411228