



CEWELD G3

TYPE	Copper-coated filler metal for gas welding (0,5% Ni)					
ANWENDUNGEN	Gas welding of steels that require good impact properties at low temperature.					
EIGENSCHAFTEN	Excellent impact properties at low temperatures due to the addition of Nickel with increased yield strenght.					
KLASSIFIKATION	AWS	A 5.2: R60				
	EN ISO	20378: O III				
	F-nr	6				
	FM	1				
GEEIGNET FÜR	Steels up to a yield strength of 275MPa (40 ksi). S185-E295, S235JR-S275JR ASTM: A36, A106 grades A/B/C, A139 grade A, A210 grades A1/C, A216 grades WCA/WCB/WCC, A234 grade WPB					
ZULASSUNGEN	CE					
SCHWEISSPOSITIONEN						
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	Ni		
	0.1	0.1	1.1	0.4		
MECHANISCHE GÜTEWERTE	Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V	Hardness
	As Welded	340	470	20	RT	HRc
					65	
RÜCKTROCKNUNG	Not required					
GAS ACC. EN ISO 14175	None					