CEWELD SG Ni1

certilas® THE FILLER METAL SPECIALIST

TYPE

Filler metal for fine grain steels and cold-tough steels.

ANWENDUNGEN

Offshore requirements at working temperatures down to -60 °C such as crane, vessel, rigs, platforms, pipelines for NACE requirements, boiler, tubing etc.

EIGENSCHAFTEN

Excellent impact properties at low temperatures due to the addition of Nickel and increased yield strenght above 460 MPa.

KLASSIFIKATION

AWS	A 5.28: ER 80S-Ni1
EN ISO	14341-A: G 50 6 M21 3Ni1
F-nr	6
FM	1

GEEIGNET FÜR

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	-

ZULASSUNGEN

CE

SCHWEISSPOSITIONEN

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	Ni
0.08	0.5	1.1	0.9

MECHANISCHE GÜTEWERTE

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				-40°C	-60°C	
As Welded	510	580	22	70	50	HRc
620°C±15°C 2h	430	540	31	110	HRc	

RÜCKTROCKNUNG

Not required

GAS ACC. EN ISO 14175

M21

CEWELD SG Ni1

SG NI1 0,8MM

Packaging	KG/unit	EanCode
BS-300	15	8720663405685

SG NI1 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663405678

SG NI1 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663416728