



# CEWELD SG 3 Tig

| TYPE  | Copper coated welding wire for GTAW welding of un and -low alloyed steels  |                |                         |                      |                     |                         |                    |          |                         |       |           |     |       |      |      |      |       |       |      |      |      |       |       |       |       |
|---|--|----------------|-------------------------|----------------------|---------------------|-------------------------|--------------------|----------|-------------------------|-------|-----------|-----|-------|------|------|------|-------|-------|------|------|------|-------|-------|-------|-------|
| APPLICATIONS                                      | Shipbuilding, piping, root welding, bridges, repair, construction, offshore, car-plate welding etc...  |                |                         |                      |                     |                         |                    |          |                         |       |           |     |       |      |      |      |       |       |      |      |      |       |       |       |       |
| PROPERTIES  | Extreme easy to weld with excellent welding properties and increased yield strength.   |                |                         |                      |                     |                         |                    |          |                         |       |           |     |       |      |      |      |       |       |      |      |      |       |       |       |       |
| CLASSIFICATION                                    | <table border="0"> <tr> <td>AWS</td> <td>A 5.18: ER 70S-6</td> </tr> <tr> <td>EN ISO</td> <td>636-A: W 50 5 4 Si1</td> </tr> <tr> <td>W.Nr.</td> <td>1.5130</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>1</td> </tr> </table>  | AWS            | A 5.18: ER 70S-6        | EN ISO               | 636-A: W 50 5 4 Si1 | W.Nr.                   | 1.5130             | F-nr     | 6                       | FM    | 1         |     |       |      |      |      |       |       |      |      |      |       |       |       |       |
| AWS   | A 5.18: ER 70S-6   |                |                         |                      |                     |                         |                    |          |                         |       |           |     |       |      |      |      |       |       |      |      |      |       |       |       |       |
| EN ISO  | 636-A: W 50 5 4 Si1  |                |                         |                      |                     |                         |                    |          |                         |       |           |     |       |      |      |      |       |       |      |      |      |       |       |       |       |
| W.Nr.   | 1.5130   |                |                         |                      |                     |                         |                    |          |                         |       |           |     |       |      |      |      |       |       |      |      |      |       |       |       |       |
| F-nr  | 6  |                |                         |                      |                     |                         |                    |          |                         |       |           |     |       |      |      |      |       |       |      |      |      |       |       |       |       |
| FM  | 1  |                |                         |                      |                     |                         |                    |          |                         |       |           |     |       |      |      |      |       |       |      |      |      |       |       |       |       |
| SUITABLE FOR                                      | <p><b>Reh ≤ 460 MPa (67 ksi) ISO 15608: 1.2, 1.3, 2.1</b><br/>           1.5637, 1.6217, 1.6228, 1.0044-1.09821.0035 - 1.0570, 1.0345, 1.0425, 1.0481, 1.0308 - 1.0581, 1.0307 - 1.0582, 1.0440, 1.0472, 1.0475, 1.0416 to 1.0551<br/>           10Ni14, 12Ni14, 13MnNi6-3, 15NiMn6,<br/>           S235JR-S355JR, S235JO-S355JO, S450JO, S235J2-S355J2, S275N-S460N, S275M-S460M,<br/>           P235GH-P355GH, P275NL1-P460NL1, P215NL, P265NL, P355N, P285NH-P460NH, P195TR1-P265TR1, P195TR2-P265TR2, P195GH-P265GH, L245NB-L415NB, L450QB, L245MB-L450MB, GE200-GE240,<br/>           A, B, D, E, A 32-E 36<br/>           ASTM A 106 Gr. A, B, C; A 181 Gr. 60, 70; A 283 Gr. A, C; A 285 Gr. A, B, C; A 350 Gr. LF1; A 414 Gr. A, B, C, D, E, F, G; A 501 Gr. B; A 513 Gr. 1018; A 516 Gr. 55, 60, 65, 70; A 573 Gr. 58, 65, 70; A 588 Gr. A, B; A 633 Gr. C, E; A 662 Gr. B; A 711 Gr. 1013; A 841 Gr. A; API 5 L Gr. B, X42, X52, X56, X60, X65<br/>           Domex 315-460MC, MC Plus, ML</p> |                |                         |                      |                     |                         |                    |          |                         |       |           |     |       |      |      |      |       |       |      |      |      |       |       |       |       |
| APPROVALS   | TÜV: 12399.00, CE  |                |                         |                      |                     |                         |                    |          |                         |       |           |     |       |      |      |      |       |       |      |      |      |       |       |       |       |
| WELDING POSITIONS                                 |  |                |                         |                      |                     |                         |                    |          |                         |       |           |     |       |      |      |      |       |       |      |      |      |       |       |       |       |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | <table border="1"> <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>0.95</td> <td>1.75</td> <td>0.012</td> <td>0.015</td> <td>0.01</td> <td>0.01</td> <td>0.01</td> <td>0.001</td> <td>0.009</td> <td>0.002</td> <td>0.013</td> </tr> </tbody> </table>   | C              | Si                      | Mn                   | P                   | S                       | Cr                 | Ni       | Mo                      | V     | Cu        | Al  | Ti+Zr | 0.08 | 0.95 | 1.75 | 0.012 | 0.015 | 0.01 | 0.01 | 0.01 | 0.001 | 0.009 | 0.002 | 0.013 |
| C   | Si   | Mn             | P                       | S                    | Cr                  | Ni                      | Mo                 | V        | Cu                      | Al    | Ti+Zr     |     |       |      |      |      |       |       |      |      |      |       |       |       |       |
| 0.08  | 0.95   | 1.75           | 0.012                   | 0.015                | 0.01                | 0.01                    | 0.01               | 0.001    | 0.009                   | 0.002 | 0.013     |     |       |      |      |      |       |       |      |      |      |       |       |       |       |
| MECHANICAL PROPERTIES                             | <table border="1"> <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>-20°C</th> <th>-40°C</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>520</td> <td>600</td> <td>24</td> <td>170</td> <td>110</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                   | -40°C | As Welded | 520 | 600   | 24   | 170  | 110  | HRC   |       |      |      |      |       |       |       |       |
| 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          | -40°C                   |                      |                     |                         |                    |          |                         |       |           |     |       |      |      |      |       |       |      |      |      |       |       |       |       |
| As Welded   | 520  | 600            | 24                      | 170                  | 110                 | HRC                     |                    |          |                         |       |           |     |       |      |      |      |       |       |      |      |      |       |       |       |       |
| REDRYING  | Not required   |                |                         |                      |                     |                         |                    |          |                         |       |           |     |       |      |      |      |       |       |      |      |      |       |       |       |       |
| GAS ACC. EN ISO 14175                             | I1   |                |                         |                      |                     |                         |                    |          |                         |       |           |     |       |      |      |      |       |       |      |      |      |       |       |       |       |



# CEWELD SG 3 Tig

SG 3 TIG 1,6 X 1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663405234 |

SG 3 TIG 2,0 X 1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663405241 |

SG 3 TIG 2,4 X 1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663405258 |

SG 3 TIG 3,0 X 1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663405265 |

SG 3 TIG 3,2 X 1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663405272 |