



CEWELD SG Ni1

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	14341-A: G 50 6 M21 3Ni1	
	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	Ni
0.08	0.5	1.1	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	510	580	22	70	50	HRc
620°C±15°C 2h	430	540	31	110	HRc	

REDRYING 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