



CEWELD SG Ni1 Tig

| | | |
|-----------------------|---|--------------------|
| 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 | 636-A: W 46 6 3Ni |
| | 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 | P | S | Ni |
|------|-----|------|-------|-------|-----|
| 0.08 | 0.5 | 1.05 | 0.007 | 0.015 | 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 | 500 | 570 | 24 | 70 | 55 | HRc |

REDRYING Not required

GAS ACC. EN ISO 14175 I1



CEWELD SG Ni1 Tig

| | | | |
|-------------------------|-----------|---------|---------------|
| SG NI1 TIG 1,6 X 1000MM | Packaging | KG/unit | EanCode |
| | Tube | 5 | 8720663405692 |
| SG NI1 TIG 2,0 X 1000MM | Packaging | KG/unit | EanCode |
| | Tube | 5 | 8720663405708 |
| SG NI1 TIG 2,4 X 1000MM | Packaging | KG/unit | EanCode |
| | Tube | 5 | 8720663405722 |
| SG NI1 TIG 3,2 X 1000MM | Packaging | KG/unit | EanCode |
| | Tube | 5 | 8720663405739 |