



# CEWELD G3

<b>TYPE</b>	Copper-coated filler metal for gas welding (0,5% Ni)					
<b>APPLICATIONS</b>	Gas welding of steels that require good impact properties at low temperature.					
<b>PROPERTIES</b>	Excellent impact properties at low temperatures due to the addition of Nickel with increased yield strenght.					
<b>CLASSIFICATION</b>	AWS	A 5.2: R60				
	EN ISO	20378: O III				
	F-nr	6				
	FM	1				
<b>SUITABLE FOR</b>	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					
<b>APPROVALS</b>	CE					
<b>WELDING POSITIONS</b>						
<b>TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)</b>	C	Si	Mn	Ni		
	0.1	0.1	1.1	0.4		
<b>MECHANICAL PROPERTIES</b>	Heat Treatment	R <sub>P0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V	Hardness
	As Welded	340	470	20	RT	HRc
					65	
<b>REDRYING</b>	Not required					
<b>GAS ACC. EN ISO 14175</b>	None					