



CEWELD SG 1 Tig

TYPE Copper coated welding wire developed for Tig welding of un and -low alloyed steels with low silicon and manganese content.

APPLICATIONS Shipbuilding, offshore, repair, construction, car-plate welding etc...

PROPERTIES Extreme easy to weld with excellent welding properties suitable for welding galvanized plates or weld deposits that have to be galvanized afterwards due to the low silicon content.

CLASSIFICATION

AWS	A 5.18: ER 70S-3
EN ISO	636-A: W 42 2 W2Si
F-nr	6
FM	1

SUITABLE FOR St 33 – St 52 ,A, E, AH, EH ,HI-HIII, 17Mn4, St 37.0/4 – St 52.0/4, StE 255 – StE 420

APPROVALS CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	P	S	Cr	Ni	Mo	V	Cu	Al	Ti+Zr
0.08	0.6	1.1	0.009	0.014	0.06	0.03	0.01	0.003	0.03	0.003	0.012

MECHANICAL PROPERTIES

Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				-20°C		
As Welded	470	560	30	100		HRc

REDRYING Not required

GAS ACC. EN ISO 14175 I1



CEWELD SG 1 Tig

SG 1 TIG 1,6 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663411198

SG 1 TIG 2,0 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663411204

SG 1 TIG 2,4 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663411211

SG 1 TIG 3,0 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663411273

SG 1 TIG 3,2 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663411228