CEWELD SG Ni2,5

certilas® THE FILLER METAL SPECIALIST

TYPE

Solid welding wire for extra low temperature applications.

APPLICATIONS

This Filler metal was developed for fine-grain steels and low-temperature steels. Typical applications are welding boilers for liquid petrol gas (LPG)

PROPERTIES

He is a copper coated, Ni-alloyed (2,4% Ni), solid wire for low temperature steels in applications such as vessels, pipes and in the offshore industry with a minimum yield strength of 470 Mpa. The wire provides excelent impact thoughness down to -60°C.

CLASSIFICATION

AWS	A 5.28: ER 80S-Ni2
EN ISO	14341-A: G 46 6 M21 2Ni2
F-nr	6
FM	1

SUITABLE FOR

For cryogenic construction steels and Ni bearing low temperature steels.
11MnNi5-3, 13MnNi6-3, 15NiMn6, S275NL-S460NL, S275ML-S460ML, P275NL2-P460NL2, P355ML2-P460ML2
ASTM: A203 grade A/B, A333/A334 grades 1/6/7, A350 grade LF2/LF5/LF6, A352 grade LC1/LC2

APPROVALS

CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	P	S	Ni
0.1	0.5	1.1	0.015	0.015	2.5

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V			Hardness
				-40°C	-60°C	-70°C	
As Welded	540	630	28	100	60	47	HRc

REDRYING

Not required

GAS ACC. EN ISO 14175

M21

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SG NI2,5 0,8MM

Packaging	KG/unit	EanCode
BS-300	15	8720663405746

SG NI2,5 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663405753

SG NI2,5 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663405760

SG NI2,5 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663405777