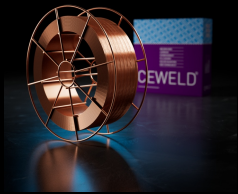


CEWELD SG Ni1

TYPE	Solidwire for fine grain steels and cold-tough steels. (G 50 6, 80S- Ni1)						
APPLICATIONS	CEWELD® SG Ni1 fulfills offshore requirements at working temperatures down to -60 °C. Areas of application are: for cranes, ships, drilling rigs, platforms, pipelines for NACE requirements, boilers, pipes, etc.						
PROPERTIES	CEWELD® SG Ni1 have excellent impact properties at low temperatures due to the addition of Nickel and increased yield strenght above 500 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	Reh ≤ 500 MPa ISO 15608: 1.2 (275 < ReH < 360 MPa), 1.3 (ReH > 360 MPa < 500 MPa) 1.8900, 1.8901, 1.8902, 1.8903, 1.8905, 1.8907, 1.8910, 1.8912, 1.8915, 1.8917, 1.8930, 1.8932, 1.8935, 1.8937, 1.8970, 1.8971, 1.8972, 1.8973, 1.8975 S460N, S420N, S460NL, P460N, StE 420, StE 460, StE 500, TStE 380, S420NL, P460NL1, P420NH, P460NH, TStE 420, TStE 460, TStE 500, WStE 380, WStE 420, WStE 460, WStE 500, StE 385.7, StE 385.7 TM, StE 415, L485ME, 11MnNi5-3, 13MnNi6-3 ASTM A 203 Gr. D, E; A 350 Gr. LF1, LF2, LF3; A 420 Gr. WPL3, WPL6; A 516 Gr. 60, 65, 70; A 572 Gr. 42, 50, 55, 60, 65; A 633 Gr. A, D, E; A 662 Gr. A, B, C; A 707 Gr. L1, L2, L3; A 738 Gr. A; A 841 A, B, C; API 5 L X52, X60, X65, X52Q, X60Q, X65Q						
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
	As Welded	510	580	22	-40°C	-60°C	
	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