



CEWELD SG 2

TYPE	ER 70S-6 welding wire for welding un and -low alloyed steels upto 420 MPa yield strength.													
APPLICATIONS	CEWELD® SG2 is a GMAW wire for joining and surfacing unalloyed and low-alloy structural steels. Typical in Shipbuilding, piping, bridges, repair, construction, car-plate welding etc...													
PROPERTIES	CEWELD® SG2 is extreme easy to weld with excellent welding properties. High world wide excepted quality with controlled cast en helix for semi and or semi-automatic applications. Weldable with Co2 and Mix gas.													
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.18: ER 70S-6</td> </tr> <tr> <td>EN ISO</td> <td>14341-A: G 42 3 C1 3Si1</td> </tr> <tr> <td>W.Nr.</td> <td>1.5125</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>1</td> </tr> </table>	AWS	A 5.18: ER 70S-6	EN ISO	14341-A: G 42 3 C1 3Si1	W.Nr.	1.5125	F-nr	6	FM	1			
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EN ISO	14341-A: G 42 3 C1 3Si1													
W.Nr.	1.5125													
F-nr	6													
FM	1													
SUITABLE FOR	<p>Reh ≤ 420 MPa (67 ksi) ISO 15608: 1.2, 1.3, 2.1 1.5637, 1.6217, 1.6228, 1.0044-1.09821.0035 - 1.0570, 1.0345, 1.0425, 1.0481, 1.0308 - 1.0581, 1.0307 - 1.0582, 1.0440, 1.0472, 1.0475, 1.0416 to 1.0551 10Ni14, 12Ni14, 13MnNi6-3, 15NiMn6, S235JR-S355JR, S235JO-S355JO, S420JO, S235J2-S355J2, S275N-S460N, S275M-S420M, P235GH-P355GH, P275NL1-P420NL1, P215NL, P265NL, P355N, P285NH-P460NH, P195TR1-P265TR1, P195TR2-P265TR2, P195GH-P265GH, L245NB-L415NB, L450QB, L245MB-L420MB, GE200-GE240, A, B, D, E, A 32-E 36 ASTM A 106 Gr. A, B, C; A 181 Gr. 60, 70; A 283 Gr. A, C; A 285 Gr. A, B, C; A 350 Gr. LF1; A 414 Gr. A, B, C, D, E, F, G; A 501 Gr. B; A 513 Gr. 1018; A 516 Gr. 55, 60, 65, 70; A 573 Gr. 58, 65, 70; A 588 Gr. A, B; A 633 Gr. C, E; A 662 Gr. B; A 711 Gr. 1013; A 841 Gr. A; API 5 L Gr. B, X42, X52, X56, X60, X65 Domex 315-460MC, MC Plus, ML</p>													
APPROVALS	TÜV: 12398.00, CE, DB: 42.206.01													
WELDING POSITIONS														
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> </tr> </thead> <tbody> <tr> <td>0.07</td> <td>0.85</td> <td>1.45</td> <td>0.015</td> <td>0.015</td> </tr> </tbody> </table>	C	Si	Mn	P	S	0.07	0.85	1.45	0.015	0.015			
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MECHANICAL PROPERTIES	<table border="1"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R_{P0.2} (MPa)</th> <th rowspan="2">R_m (MPa)</th> <th rowspan="2">A₅ (%)</th> <th>Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th>-40°C</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>440</td> <td>560</td> <td>30</td> <td>90</td> <td>HRc</td> </tr> </tbody> </table>	Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V	Hardness	-40°C	As Welded	440	560	30	90	HRc
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		-40°C												
As Welded	440	560	30	90	HRc									
REDRYING	Not required													
GAS ACC. EN ISO 14175	M21, C1													



CEWELD SG 2

SG 2 0,6MM

Packaging	KG/unit	EanCode
D-100	4x1,0	8720663404893
D-200	5	8720663404916
D-300	15	8720663404923

SG 2 0,8MM

Packaging	KG/unit	EanCode
BS-300	15	8720663405029
BS-300 Uncoppered	15	8720663405043
D-100	4x0,8	8720663404954
D-200	5	8720663404992
D-300	15	8720663405005
Drum	250	8720663405012

SG 2 0,9MM

Packaging	KG/unit	EanCode
D-200	5	8720663405081
Drum	250	8720663405074

SG 2 1,0MM

Packaging	KG/unit	EanCode
BS-300	1	8720663405135
BS-300 Uncoppered	15	8720663405173
D-200	5	8720663405142
D-300	15	8720663405180
Drum	250	8720663405197

SG 2 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663405425
BS-300 Uncoppered	15	8720663405487
D-200	5	8720663405456
D-300	15	8720663405463
Drum	250	8720663405494
Drum Uncoppered	250	8720663424778