



# CEWELD SG Ni1 Tig

<b>TYPE</b>	Filler metal for fine grain steels and cold-tough steels.	
<b>APPLICATIONS</b>	Offshore requirements at working temperatures down to -60° C such as crane, vessel, rigs, platforms, pipelines for NACE requirements, boiler, tubing etc.	
<b>PROPERTIES</b>	Excellent impact properties at low temperatures due to the addition of Nickel and increased yield strength above 460 MPa.	
<b>CLASSIFICATION</b>	AWS	A 5.28: ER 80S-Ni1
	EN ISO	636-A: W 46 6 3Ni
	F-nr	6
	FM	1

<b>SUITABLE FOR</b>	<b>Materials</b>	<b>DIN</b>	<b>EN</b>	<b>ASTM</b>
	shipbuilding	A, B, D, E, AH 32 - EH 36	same	Typical
	Unalloyed steels	St 33, St 37-2 - St 52-3	S185 - S355-S460	A 258 / A 516
	boiler steels	H I, H III, 17Mn4, 19Mn5	P235GH, P355GH	A 662 / A 387
	pipe steels	St 35.8, St 45.8	P235T1/T2, P460NL2	A 738 / A 612
	-	StE 210.7 TM, StE 480.7 TM	L210 - L480MB	A 299
	Fine grain steels	StE 255 to StE 460	S255 - S500 (NL1,2)	-
API-standard	X 42, X65	X 42, X65	-	

**APPROVALS** CE

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)**

C	Si	Mn	P	S	Ni
0.08	0.5	1.05	0.007	0.015	0.9

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
				-40°C	-60°C	
As Welded	500	570	24	70	55	HRc

**REDRYING** Not required

**GAS ACC. EN ISO 14175** I1



# CEWELD SG Ni1 Tig

SG NI1 TIG 1,6 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663405692
SG NI1 TIG 2,0 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663405708
SG NI1 TIG 2,4 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663405722
SG NI1 TIG 3,2 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663405739