



CEWELD SG Ni1

TYPE	Filler metal for fine grain steels and cold-tough steels.						
APPLICATIONS	Offshore requirements at working temperatures down to -60 °C such as crane, vessel, rigs, platforms, pipelines for NACE requirements, boiler, tubing etc.						
PROPRIÉTÉS	Excellent impact properties at low temperatures due to the addition of Nickel and increased yield strenght above 460 MPa.						
CLASSIFICATION	AWS	A 5.28: ER 80S-Ni1					
	EN ISO	14341-A: G 50 6 M21 3Ni1					
	F-nr	6					
	FM	1					
CONVIENT POUR	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						
AGRÉMENTS	CE						
POSITIONS DE SOUDAGE	      						
ANALYSE CHIMIQUE TYPIQUE DU MÉTAL D'APPORT (%)	C	Si		Mn		Ni	
	0.08	0.5		1.1		0.9	
PROPRIÉTÉS MÉCANIQUES	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	
ETUVAGE	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