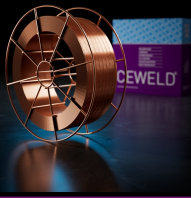


CEWELD SG 2

| TYPE | SG 2 lasdraad voor het Mag (GMAW) lassen van ongelegeerde staalsoorten | | | | | | | | | | | | | |
|---|--|----------------|-------------------------|----------------------|-------------------------|-------------------------|----------|--------------------|-------------------------|----------|-------|----|----|-----|
| TOEPASSINGEN | Scheepsbouw, pijpleiding, grondnaden, bruggen, algemene constructie, carrosserie plaatwerk, hekwerk etc. | | | | | | | | | | | | | |
| EIGENSCHAPPEN | <p>Uitmuntende laseigenschappen in een breed werkgebied van kortsluitboog tot aan sproeihoog met weinig silicaten als gevolg van de hoge zuiverheid van de neersmelt.</p> <p>De voorbuiging (cast) van deze lasdraad ligt ruim boven de gestelde Europese normen en dragen bij aan een stabielere stroomoverdracht en een rustigere boog met minder spatverliezen. De nauwe tolerantie op helix maakt CEWELD SG 2 een uitmuntende keus voor geautomatiseerde of robot opstellingen waarbij het relatief hoge percentage Silicium zorgt voor een perfecte aanvlloeing en een zeer fijn getekend lasuiterlijk. Geschikt voor het lassen onder menggas en onder Co2</p> | | | | | | | | | | | | | |
| CLASSIFICATIE | <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 | | | |
| 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 | | | | | | | | | | | | | |
| GESCHIKT VOOR | <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> | | | | | | | | | | | | | |
| GOEDKEURINGEN | TÜV: 12398.00, CE, DB: 42.206.01 | | | | | | | | | | | | | |
| LASPOSITIES | | | | | | | | | | | | | | |
| 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 | | | |
| C | Si | Mn | P | S | | | | | | | | | | |
| 0.07 | 0.85 | 1.45 | 0.015 | 0.015 | | | | | | | | | | |
| MECHANISCHE WAARDEN | <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 |
| 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 | | | | | | | | | |
| HERDROGEN | 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 |