



CEWELD SG Ni3,5 Tig

TYPE Solid Tig welding wire for extra low temperature applications.(Ni3,5)

APPLICATIONS CEWELD® SG Ni3,5 Tig was developed for fine-grain steels and low-temperature steels. Typical applications are welding boilers for liquid petrol gas (LPG). For cryogenic construction steels and Ni bearing low temperature steels.

PROPERTIES CEWELD® SG Ni3.5 Tig is a copper-coated, Ni-alloyed (3,5% Ni) solid wire for low temperature steels with a minimum yield strength > 550 Mpa. The wire offers excellent impact strength down to -70°C. (-80°C >27 J)

CLASSIFICATION AWS A 5.28: ER 80S-Ni3

SUITABLE FOR **ReH ≤ 550 MPa ISO 15608: 1.2 (275 < ReH < 360 MPa), 1.3 (ReH > 360 MPa < 550 MPa), 2.2 ReH > 460 MPa**
1.0531, 1.0984, 1.0986, 1.8900, 1.8901, 1.8902, 1.8903, 1.8904, 1.8905, 1.8907, 1.8910, 1.8912, 1.8915, 1.8917, 1.8926, 1.8930, 1.8932, 1.8935, 1.8937, 1.8986, 1.8970, 1.8971, 1.8972, 1.8973, 1.8975
11MnNi5-3, 13MnNi6-3, 12Ni14, S460N, S420N, S460NL, P460N, StE 420, StE 460, StE 500, StE 550 TStE 380, S420NL, P460NL1, P420NH, P460NH, TStE 420, TStE 460, TStE 500, TStE 550 WStE 380, WStE 420, WStE 460, WStE 500, WStE 550, StE 385.7, StE 385.7 TM, StE 415, L485ME
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
Oceanfit 52, Oceanfit 60, Oceanfit 65, Oceanfit 355, Oceanfit 420, Oceanfit 460, PAS 460-550, alform® 500 M, 550 M, aldur 500 Q, 500 QL, aldur 550 Q, 550 QL

APPROVALS

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Ni	Cu
0.1	0.6	1	0.015	0.015	3.5	0.12

MECHANICAL PROPERTIES

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				-60°C	-70°C	
As Welded	570	640	24	70	50	HRc

REDRYING Not required

GAS ACC. EN ISO 14175



CEWELD SG Ni3,5 Tig

SG NI3,5 TIG 2,4 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663406149

SG NI3,5 TIG 3,2 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663406156