



CEWELD SG Ni1 Tig

TYPE	Filler metal for fine grain steels and cold-tough steels.						
TOEPASSINGEN	Offshore requirements at working temperatures down to -60° C such as crane, vessel, rigs, platforms, pipelines for NACE requirements, boiler, tubing etc.						
EIGENSCHAPPEN	Excellent impact properties at low temperatures due to the addition of Nickel and increased yield strength above 460 MPa.						
CLASSIFICATIE	AWS	A 5.28: ER 80S-Ni1					
	EN ISO	636-A: W 46 6 3Ni					
	F-nr	6					
	FM	1					
GESCHIKT VOOR	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						
GOEDKEURINGEN	CE						
LASPOSITIES	      						
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	
MECHANISCHE WAARDEN	Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
					-40°C	-60°C	
	As Welded	500	570	24	70	55	HRc
HERDROGEN	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