



CEWELD SG 2 Tig

TYPE Copper coated welding rod for welding un and -low alloyed steels upto 420 MPa yield strength.(ER70S6, 3Si1)

APPLICATIONS CEWELD® SG2 Tig is a Tig-Rod for joining and surfacing unalloyed and low-alloy structural steels. Typical in Shipbuilding, piping, bridges, repair, construction, car-plate welding etc. Suitable for sour gas applications due to the very low P/S/Ni content

PROPERTIES CEWELD® SG2 Tig is extreme easy to weld with excellent welding properties. High world wide excepted quality with controlled cast en helix for semi and or semi-automatic applications.

CLASSIFICATION	AWS	A 5.18: ER 70S-6
	EN ISO	636-A: W 46 5 3Si1
	F-nr	6
	FM	1
	W.Nr.	1.5125

SUITABLE FOR **Rp < 420 MPa (60ksi) ISO 15608: 1.1(ReH < 275 MPa), 1.2 (275 < ReH < 360 MPa), 1.3 (ReH > 360 MPa < 420 MPa)**
 1.0035, 1.0038, 1.0039, 1.0044, 1.0112, 1.0116, 1.0130, 1.0145, 1.0253, 1.0254, 1.0255, 1.0258, 1.0259, 1.0319, 1.0345, 1.0345, 1.0345, 1.0348, 1.0352, 1.0418, 1.0420, 1.0425, 1.0425, 1.0425, 1.0451, 1.0452, 1.0453, 1.0457, 1.0459, 1.0460, 1.0461, 1.0486, 1.0490, 1.0491, 1.0619, 1.1100, 1.0409, 1.0421, 1.0426, 1.0429, 1.0430, 1.0436, 1.0473, 1.0481, 1.0482, 1.0484, 1.0505, 1.0545, 1.0546, 1.0562, 1.0566, 1.0570, 1.0578, 1.0581, 1.0582, 1.8902, 1.8912, 1.8932
 10Ni14, 12Ni14, 13MnNi6-3, 15NiMn6,
 S235JR-S355JR, S235JO-S355JO, P195TR1-P265TR1, P195GH-P265GH, L245NB-L360NB, L245MB-L360MB, L415NB, L415MB, WStE 380, WStE 420, S420NL
 A, B, D, E, A 32-E 36
ASTM A 105, A 106, Gr. A, B; A 283 Gr. A, C; A 285 Gr. A, B, C; A 501, Gr. B; A 573, Gr. 58, 65, 70; A 633, Gr. A, C; A 711 Gr. 1013;
API 5 L Gr. B, X42, X52, X60
 Domex 315-420MC, MC Plus, ML

APPROVALS TÜV ((19806)) CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn
	0.08	0.85	1.45

ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R _{p0,2} MPa	R _m MPa	A5 (%)	RT	Impact Energy (J) ISO-V	
						-40°C	-50°C
	As Welded /	450	560	24	200	150	60

REDRYING TEMPERATURE Not required

GAS ACCORDING EN 14175 I1



CEWELD SG 2 Tig

SG 2 TIG 0,8 X 1000MM

Type	KG/unit	EANCode
Tube	5	8720663411235

SG 2 TIG 1,0 X 1000MM

Type	KG/unit	EANCode
Tube	5	8720663411242

SG 2 TIG 1,2 X 1000MM

Type	KG/unit	EANCode
Tube	5	8720663411259

SG 2 TIG 1,6 X 1000MM

Type	KG/unit	EANCode
Tube	5	8720663411266

SG 2 TIG 2,0 X 1000MM

Type	KG/unit	EANCode
Tube	5	8720663411280

SG 2 TIG 2,4 X 1000MM

Type	KG/unit	EANCode
Tube	5	8720663411297

SG 2 TIG 3,0 X 1000MM

Type	KG/unit	EANCode
Tube	5	8720663411303

SG 2 TIG 3,2 X 1000MM

Type	KG/unit	EANCode
Tube	5	8720663411310

SG 2 TIG 4,0 X 1000MM

Type	KG/unit	EANCode
Tube	5	8720663411327

SG 2 TIG 5,0 X 1000MM

Type	KG/unit	EANCode
Tube	5	8720663411334