



CEWELD SG 3

TYPE	Copper coated welding wire for MAG welding of un and -low alloyed steels														
APPLICATIONS	CEWELD® SG 3 can be used universally in tank, boiler and general steel construction as well as in shipbuilding and pipeline construction, especially for root welding. Also suitable for sour gas applications due to its very low P/S/Ni content.														
PROPERTIES	CEWELD® SG 3 is extreme easy to weld with excellent welding properties and increased yield strength. Weldable with CO2 and Mix gas.														
CLASSIFICATION	<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 46 4 M21 4Si1</td> </tr> <tr> <td>EN ISO</td> <td>14341-A: G 42 4 C1 4Si1</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>1</td> </tr> <tr> <td>W.Nr.</td> <td>1.5130</td> </tr> </table>	AWS	A 5.18: ER 70S-6	EN ISO	14341-A: G 46 4 M21 4Si1	EN ISO	14341-A: G 42 4 C1 4Si1	F-nr	6	FM	1	W.Nr.	1.5130		
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F-nr	6														
FM	1														
W.Nr.	1.5130														
SUITABLE FOR	<p>Reh ≤ 460 MPa (67 ksi) ISO 15608: 1.2, 1.3, 2.1 (Mix gas) 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, S450JO, S235J2-S355J2, S275N-S460N, S275M-S460M, P235GH-P355GH, P275NL1-P460NL1, P215NL, P265NL, P355N, P285NH-P460NH, P195TR1-P265TR1, P195TR2-P265TR2, P195GH-P265GH, L245NB-L415NB, L450QB, L245MB-L450MB, 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>														
APPROVALS	TÜV ((12399)) CE DB ((42.206.02))														
WELDING POSITIONS															
TYPICAL CHEMICAL ANALYSIS OF THE FILLER 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>0.08</td> <td>0.9</td> <td>1.75</td> <td>0.015</td> <td>0.015</td> </tr> </tbody> </table>	C	Si	Mn	P	S	0.08	0.9	1.75	0.015	0.015				
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ALL WELD MECHANICAL PROPERTIES	<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 colspan="2">Impact Energy (J) ISO-V</th> </tr> <tr> <th>RT</th> <th>-40°C</th> </tr> </thead> <tbody> <tr> <td>As Welded /</td> <td>490</td> <td>620</td> <td>26</td> <td>170</td> <td>93</td> </tr> </tbody> </table>	Heat Treatment	R _{P0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V		RT	-40°C	As Welded /	490	620	26	170	93
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		RT	-40°C												
As Welded /	490	620	26	170	93										
REDRYING TEMPERATURE	Not required														
GAS ACCORDING EN 14175	M21, C1														



CEWELD SG 3

SG 3 0,8MM

Type	KG/unit	EANCode
BS-300	15	8720663405210
D-200	5	8720663405050

SG 3 1,0MM

Type	KG/unit	EANCode
D-100	1	8720663405289
D-200	5	8720663405296
Drum	250	8720663405302

SG 3 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663405104
Drum	250	8720663405111

SG 3 1,4MM

Type	KG/unit	EANCode
Drum	250	8720663405128

SG 3 1,6MM

Type	KG/unit	EANCode
BS-300	15	8720663405098