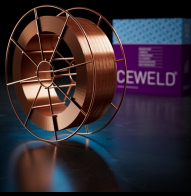


CEWELD SG 3

TYPE	Copper coated welding wire for MAG welding of un and -low alloyed steels														
APPLICATIONS	Shipbuilding, piping, root welding, bridges, repair, construction, offshore, car-plate welding etc...														
PROPERTIES	Extreme easy to weld with excellent welding properties and increased yield strength. High world wide excepted quality with controlled cast and helix for semi and or semi-automatic applications. 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 42 4 C1 4Si1</td> </tr> <tr> <td>EN ISO</td> <td>14341-A: G 46 4 M21 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 42 4 C1 4Si1	EN ISO	14341-A: G 46 4 M21 4Si1	F-nr	6	FM	1	W.Nr.	1.5130		
AWS	A 5.18: ER 70S-6														
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EN ISO	14341-A: G 46 4 M21 4Si1														
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 (12399.00) 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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0.08	0.9	1.75	0.015	0.015											
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>110</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	110
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		RT	-40°C												
As Welded /	490	620	26	170	110										
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
Drum	250	8720663405227

SG 3 1,0MM

Type	KG/unit	EANCode
BS-300	15	8720663405203
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