



CEWELD SG Ni1

TYPE	Filler metal for fine grain steels and cold-tough steels.		
APPLICATIONS	Offshore requirements at working temperatures down to -60 °C such as crane, vessel, rigs, platforms, pipelines for NACE requirements, boiler, tubing etc.		
PROPERTIES	Excellent impact properties at low temperatures due to the addition of Nickel and increased yield strenght above 460 MPa.		
CLASSIFICATION	AWS	A 5.28: ER 80S-Ni1	
	EN ISO	14341-A: G 50 6 M21 3Ni1	
	F-nr	6	
	FM	1	

SUITABLE FOR	Materials	DIN	EN	ASTM
	shipbuilding	A, B, D, E, AH 32 - EH 36	same	Typical
	Unalloyed steels	St 33, St 37-2 - St 52-3	S185 - S355-S460	A 258 / A 516
	boiler steels	H I, H III, 17Mn4, 19Mn5	P235GH, P355GH	A 662 / A 387
	pipe steels	St 35.8, St 45.8	P235T1/T2, P460NL2	A 738 / A 612
	-	StE 210.7 TM, StE 480.7 TM	L210 - L480MB	A 299
	Fine grain steels	StE 255 to StE 460	S255 - S500 (NL1,2)	-
API-standard	X 42, X65	X 42, X65	-	

APPROVALS CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

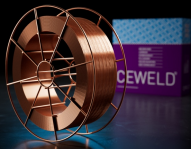
C	Si	Mn	Ni
0.08	0.5	1.1	0.9

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{P0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V	
				-40°C	-60°C
As Welded / 620°C±15°C /2h	510 / 430	580 / 540	22 / 31	70 / 110	50

REDRYING TEMPERATURE Not required

GAS ACCORDING EN 14175 M21



CEWELD SG Ni1

SG Ni1 0,8MM

Type	KG/unit	EANCode
BS-300	15	8720663405685

SG Ni1 1,0MM

Type	KG/unit	EANCode
BS-300	15	8720663405678

SG Ni1 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663416728