



CEWELD Ultra Clean III

TYPE	High strength, Copper free, Low fume ER 70S-6 welding wire for high demanding structures up-to 460 MPa Yield strength.																		
APPLICATIONS	CEWELD® Ultra Clean III can be used universally in tank, boiler and general steel construction as well as in shipbuilding and pipeline construction... Due to its metallurgical purity and nickel content of less than 1%, CEWELD® UltraClean III meets most NACE standards for sour gas applications.																		
PROPERTIES	CEWELD® Ultra Clean III has one of the lowest fume emissions of any welding wire on the market. As a virtually copper-free wire with a maximum of 0.03% copper, it is very environmentally friendly to manufacture and use. But what really sets it apart is the protection of the welder's health, as exposure to copper during welding is virtually eliminated. Arc stability is improved by a special coating which also reduces friction in the torch by approximately 50% compared to copper coated welding wire. The weld is virtually free of silicates, minimising the need for rework. CEWELD® Ultra Clean III offers excellent impact properties down to -60°C due to the pure weld metal analysis.																		
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 5 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> </table>	AWS	A 5.18: ER 70S-6	EN ISO	14341-A: G 46 5 M21 4Si1	EN ISO	14341-A: G 42 4 C1 4Si1	F-nr	6	FM	1								
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SUITABLE FOR	<p>Reh ≤ 460 MPa (67 ksi) ISO 15608: 1.2, 1.3, 2.1 (Mix gas M2, M3) 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	CE TÜV ((20200)) DB ((42.206.04)) Lloyds (in progress) DNV (in progress)																		
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> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>Cu</th> </tr> </thead> <tbody> <tr> <td>0.08</td> <td>0.8</td> <td>1.7</td> <td>0.012</td> <td>0.015</td> <td>0.01</td> <td>0.025</td> <td>0.01</td> <td>0.01</td> </tr> </tbody> </table>	C	Si	Mn	P	S	Cr	Ni	Mo	Cu	0.08	0.8	1.7	0.012	0.015	0.01	0.025	0.01	0.01
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ALL WELD MECHANICAL PROPERTIES	<table border="1"> <thead> <tr> <th>Heat Treatment</th> <th>R_{p0,2} MPa</th> <th>R_m MPa</th> <th>A₅ (%)</th> <th>Impact Energy (J) ISO-V -50°C</th> </tr> </thead> <tbody> <tr> <td>As Welded /</td> <td>520</td> <td>612</td> <td>26</td> <td>103</td> </tr> </tbody> </table>	Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V -50°C	As Welded /	520	612	26	103								
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As Welded /	520	612	26	103															
REDRYING TEMPERATURE	Not required																		
GAS ACCORDING EN 14175	M20, M21, C1																		



CEWELD Ultra Clean III

ULTRA CLEAN III 0,8MM

Type	KG/unit	EANCode
D-200	5	8720682051610
BS-300	16	8720682051603
Drum	250	8720682051597

ULTRA CLEAN III 1,0MM

Type	KG/unit	EANCode
D-200	5	8720682051566
BS-300	16	8720682051337
Drum	250	8720682051375

ULTRA CLEAN III 1,2MM

Type	KG/unit	EANCode
D-200	5	8720682051559
BS-300	16	8720682051344
Drum	250	8720682051382