



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>W.Nr.</td> <td>1.5130</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 42 4 C1 4Si1 | W.Nr. | 1.5130 | F-nr | 6 | FM | 1 | | | | | | |
| AWS | A 5.18: ER 70S-6 | | | | | | | | | | | | | | | | |
| EN ISO | 14341-A: G 42 4 C1 4Si1 | | | | | | | | | | | | | | | | |
| W.Nr. | 1.5130 | | | | | | | | | | | | | | | | |
| F-nr | 6 | | | | | | | | | | | | | | | | |
| FM | 1 | | | | | | | | | | | | | | | | |
| SUITABLE FOR | <p>Reh ≤ 460 MPa (67 ksi) ISO 15608: 1.2, 1.3, 2.1 (Mix gas)</p> <p>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</p> <p>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 | | | | | | |
| C | Si | Mn | P | S | | | | | | | | | | | | | |
| 0.08 | 0.9 | 1.75 | 0.015 | 0.015 | | | | | | | | | | | | | |
| 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> <th rowspan="2">Hardness</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> <td>HRc</td> </tr> </tbody> </table> | Heat Treatment | R _{p0,2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | | Hardness | RT | -40°C | As Welded | 490 | 620 | 26 | 170 | 110 | HRc |
| Heat Treatment | R _{p0,2} (MPa) | | | | | R _m (MPa) | A ₅ (%) | | Impact Energy (J) ISO-V | | Hardness | | | | | | |
| | | RT | -40°C | | | | | | | | | | | | | | |
| As Welded | 490 | 620 | 26 | 170 | 110 | HRc | | | | | | | | | | | |
| REDRYING | Not required | | | | | | | | | | | | | | | | |
| GAS ACC. EN ISO 14175 | M21, C1 | | | | | | | | | | | | | | | | |



CEWELD SG 3

SG 3 0,8MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| BS-300 | 15 | 8720663405210 |
| D-200 | 5 | 8720663405050 |
| Drum | 250 | 8720663405227 |

SG 3 1,0MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| BS-300 | 15 | 8720663405203 |
| D-100 | 1 | 8720663405289 |
| D-200 | 5 | 8720663405296 |
| Drum | 250 | 8720663405302 |

SG 3 1,2MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| BS-300 | 15 | 8720663405104 |
| Drum | 250 | 8720663405111 |

SG 3 1,4MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| Drum | 250 | 8720663405128 |

SG 3 1,6MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| BS-300 | 15 | 8720663405098 |