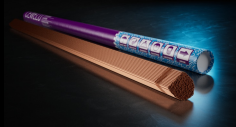


CEWELD SG 2 Tig

TYPE	Copper coated welding rod for welding un and -low alloyed steels upto 420 MPa yield strength.(ER70S6, 3Si1)																			
APPLICATIONS	CEWELD® SG2 Tig is a Tig-Rod for joining and surfacing unalloyed and low-alloy structural steels. Typical in Shipbuilding, piping, bridges, repair, construction, car-plate welding etc. Suitable for sour gas applications due to the very low P/S/Ni content																			
PROPERTIES	CEWELD® SG2 Tig is extreme easy to weld with excellent welding properties. High world wide excepted quality with controlled cast en helix for semi and or semi-automatic applications.																			
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.18: ER 70S-6</td> </tr> <tr> <td>EN ISO</td> <td>636-A: W 46 5 3Si1</td> </tr> <tr> <td>W.Nr.</td> <td>1.5125</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	636-A: W 46 5 3Si1	W.Nr.	1.5125	F-nr	6	FM	1									
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W.Nr.	1.5125																			
F-nr	6																			
FM	1																			
SUITABLE FOR	<p>Rp < 420 MPa (60ksi) ISO 15608: 1.1(ReH < 275 MPa), 1.2 (275 < ReH < 360 MPa), 1.3 (ReH > 360 MPa < 420 MPa)</p> <p>1.0035, 1.0038, 1.0039, 1.0044, 1.0112, 1.0116, 1.0130, 1.0145, 1.0253, 1.0254, 1.0255, 1.0258, 1.0259, 1.0319, 1.0345, 1.0345, 1.0345, 1.0348, 1.0352, 1.0418, 1.0420, 1.0425, 1.0425, 1.0425, 1.0451, 1.0452, 1.0453, 1.0457, 1.0459, 1.0460, 1.0461, 1.0486, 1.0490, 1.0491, 1.0619, 1.1100, 1.0409, 1.0421, 1.0426, 1.0429, 1.0430, 1.0436, 1.0473, 1.0481, 1.0482, 1.0484, 1.0505, 1.0545, 1.0546, 1.0562, 1.0566, 1.0570, 1.0578, 1.0581, 1.0582, 1.8902, 1.8912, 1.8932</p> <p>10Ni14, 12Ni14, 13MnNi6-3, 15NiMn6, S235JR-S355JR, S235JO-S355JO, P195TR1-P265TR1, P195GH-P265GH, L245NB-L360NB, L245MB-L360MB, L415NB, L415MB, WStE 380, WStE 420, S420NL</p> <p>A, B, D, E, A 32-E 36</p> <p>ASTM A 105, A 106, Gr. A, B; A 283 Gr. A, C; A 285 Gr. A, B, C; A 501, Gr. B; A 573, Gr. 58, 65, 70; A 633, Gr. A, C; A 711 Gr. 1013;</p> <p>API 5 L Gr. B, X42, X52, X60</p> <p>Domex 315-420MC, MC Plus, ML</p>																			
APPROVALS	TÜV: (19806), CE																			
WELDING POSITIONS																				
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> </tr> </thead> <tbody> <tr> <td>0.08</td> <td>0.85</td> <td>1.45</td> </tr> </tbody> </table>	C	Si	Mn	0.08	0.85	1.45													
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MECHANICAL PROPERTIES	<table border="1"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">Rp0,2 (MPa)</th> <th rowspan="2">Rm (MPa)</th> <th rowspan="2">A5 (%)</th> <th colspan="3">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th>RT</th> <th>-40°C</th> <th>-50°C</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>450</td> <td>560</td> <td>24</td> <td>200</td> <td>150</td> <td>60</td> <td>HRc</td> </tr> </tbody> </table>	Heat Treatment	Rp0,2 (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V			Hardness	RT	-40°C	-50°C	As Welded	450	560	24	200	150	60	HRc
Heat Treatment	Rp0,2 (MPa)					Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V			Hardness									
		RT	-40°C	-50°C																
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REDRYING	Not required																			
GAS ACC. EN ISO 14175	I1																			



CEWELD SG 2 Tig

SG 2 TIG 0,8 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663411235
SG 2 TIG 1,0 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663411242
SG 2 TIG 1,2 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663411259
SG 2 TIG 1,6 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663411266
SG 2 TIG 2,0 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663411280
SG 2 TIG 2,4 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663411297
SG 2 TIG 3,0 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663411303
SG 2 TIG 3,2 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663411310
SG 2 TIG 4,0 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663411327
SG 2 TIG 5,0 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663411334