CEWELD SG 3

certilas® THE FILLER METAL SPECIALIST

TYPE	Copper coated welding wire for MAG welding of un and -low alloyed steels
APPLICATIONS	CEWELD® SG 3 can be used universally in tank, boiler and general steel construction as well as in shipbuilding and pipeline construction, especially for root welding. Also suitable for sour gas applications due to its very low P/S/Ni content.
PROPERTIES	CEWELD® SG 3 is extreme easy to weld with excellent welding properties and increased yield strength. Weldable with CO2 and Mix gas.

CLASSIFICATION

AWS	A 5.18: ER 70S-6
EN ISO	14341-A: G 46 4 M21 4Si1, 14341-A: G 42 4 C1 4Si1
W.Nr.	1.5130
F-nr	6
FM	1

SUITABLE FOR

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

APPROVALS: TÜV: (12399), CE, DB: (42.206.02)

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	P	S
0.08	0.9	1.75	0.015	0.015

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				RT	-40°C	
As Welded	490	620	26	170	93	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

SG 3 1,0MM

Packaging	KG/unit	EanCode
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