



# CEWELD SG Ni1 Tig

|                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                         |                      |                    |                         |       |          |
|---------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------|----------------------|--------------------|-------------------------|-------|----------|
| TYPE                                              | Tig - rod for fine grain steels and cold-tough steels. (G 50 6, 80S- Ni1)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                         |                      |                    |                         |       |          |
| APPLICATIONS                                      | CEWELD® SG Ni1 Tig fulfills offshore requirements at working temperatures down to -60 °C.<br>Areas of application are: for cranes, ships, drilling rigs, platforms, pipelines for NACE requirements, boilers, pipes, etc.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                         |                      |                    |                         |       |          |
| PROPERTIES                                        | CEWELD® SG Ni1 Tig have excellent impact properties at low temperatures due to the addition of Nickel and increased yield strenght above 500 MPa.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |                         |                      |                    |                         |       |          |
| CLASSIFICATION                                    | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | A 5.28: ER 80S-Ni1      |                      |                    |                         |       |          |
|                                                   | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | 636-A: W 46 6 3Ni       |                      |                    |                         |       |          |
|                                                   | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | 6                       |                      |                    |                         |       |          |
|                                                   | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | 1                       |                      |                    |                         |       |          |
| SUITABLE FOR                                      | <b>ReH ≤ 500 MPa ISO 15608: 1.2 (275 &lt; ReH &lt; 360 MPa), 1.3 (ReH &gt; 360 MPa &lt; 500 MPa)</b><br>1.8900, 1.8901, 1.8902, 1.8903, 1.8905, 1.8907, 1.8910, 1.8912, 1.8915, 1.8917, 1.8930, 1.8932, 1.8935, 1.8937, 1.8970, 1.8971, 1.8972, 1.8973, 1.8975<br>S460N, S420N, S460NL, P460N, StE 420, StE 460, StE 500, TStE 380, S420NL, P460NL1, P420NH, P460NH, TStE 420, TStE 460, TStE 500, WStE 380, WStE 420, WStE 460, WStE 500, StE 385.7, StE 385.7 TM, StE 415, L485ME, 11MnNi5-3, 13MnNi6-3<br>ASTM A 203 Gr. D, E; A 350 Gr. LF1, LF2, LF3; A 420 Gr. WPL3, WPL6; A 516 Gr. 60, 65, 70; A 572 Gr. 42, 50, 55, 60, 65; A 633 Gr. A, D, E; A 662 Gr. A, B, C; A 707 Gr. L1, L2, L3; A 738 Gr. A; A 841 A, B, C; API 5 L X52, X60, X65, X52Q, X60Q, X65Q |                         |                      |                    |                         |       |          |
| APPROVALS                                         | CE                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                         |                      |                    |                         |       |          |
| WELDING POSITIONS                                 |                                                                                                                                                                 |                         |                      |                    |                         |       |          |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | Si                      | Mn                   | P                  | S                       | Ni    |          |
|                                                   | 0.08                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | 0.5                     | 1.05                 | 0.007              | 0.015                   | 0.9   |          |
| MECHANICAL PROPERTIES                             | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | R <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |       | Hardness |
|                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                         |                      |                    | -40°C                   | -60°C |          |
|                                                   | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | 500                     | 570                  | 24                 | 70                      | 55    | HRc      |
| REDRYING                                          | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                         |                      |                    |                         |       |          |
| GAS ACC. EN ISO 14175                             | I1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                         |                      |                    |                         |       |          |



# CEWELD SG Ni1 Tig

SG NI1 TIG 1,6 X 1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663405692 |

SG NI1 TIG 2,0 X 1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663405708 |

SG NI1 TIG 2,4 X 1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663405722 |

SG NI1 TIG 3,2 X 1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663405739 |