



CEWELD SG3 NiMo1

TYPE	Solid welding wire for fine grain steels and cold-tough steels.						
APPLICATIONS	Offshore drilling equipment, crane building, pipeline, platforms, Vessel, riser piping etc.						
PROPRIÉTÉS	CEWELD SG3 NiMo1 is a 0.9% Ni-alloyed, high manganese containing, copper-coated, solid wire for the GMAW/GTAW of low-temperature, fine-grained steels suitable for NACE requirements. The deposit provides good impact toughness down to -50°C and is especially suitable for use in the offshore industry such as riser pipes that often are heat treated after welding..						
CLASSIFICATION	AWS	A 5.28: ER 90S-G					
	EN ISO	16834-A: G 62 6 M21 Mn3Ni1Mo					
	F-nr	6					
	FM	2					
CONVIENT POUR	ReH ≤ 620 MPa ISO 15608: 1.3 (ReH > 360 MPa < 620 MPa), 2.2 ReH > 460 MPa 1.0531,1.0984, 1.0986, 1.8900, 1.8901, 1.8902, 1.8903, 1.8904, 1.8905, 1.8907, 1.8910, 1.8912, 1.8915, 1.8917, 1.8926, 1.8930, 1.8932, 1.8935, 1.8937, 1.8986, 1.8970, 1.8971, 1.8972, 1.8973, 1.8975 TStE 550 WStE 380, WStE 420, WStE 460, WStE 500, WstE 550, StE 385.7, StE 385.7 TM, StE 415, L485ME, 25CrMo4, 42CrMo4 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 Oceanfit 52, Oceanfit 60, Oceanfit 65, Oceanfit 355, Oceanfit 420, Oceanfit 460, PAS 460-550, alform® 500 M, 550 M, aldur 500 Q, 500 QL, aldur 550 Q, 550 QL						
AGRÉMENTS	CE						
POSITIONS DE SOUDAGE	     						
ANALYSE CHIMIQUE TYPIQUE DU MÉTAL D'APPORT (%)	C	Si	Mn	P	S	Ni	Mo
	0.12	0.5	1.75	0.01	0.01	0.9	0.55
PROPRIÉTÉS MÉCANIQUES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
					-50°C		
	As Welded	640	740	20	100		HRc
ETUVAGE	Not required						
GAS ACC. EN ISO 14175	M21						



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SG3 NIM01 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663405661