



CEWELD SG Ni2,5 Tig

TYPE	Solid welding wire for extra low temperature applications.							
APPLICATIONS	Filler metal developed for fine grain steels and cold-tough steels. Typical applications are welding boilers for liquid petrol gas (LPG)							
PROPRIÉTÉS	A copper coated, Ni-alloyed (2,4% Ni), solid wire for low temperature steels in applications such as vessels, pipes and in the offshore industry with a minimum yield strength of 470 MPa. The wire provides excellent impact toughness down to -60°C.							
CLASSIFICATION	AWS	A 5.28: ER 80S-Ni2						
	EN ISO	636-A: W 42 9 2Ni2						
	F-nr	6						
	FM	1						
CONVIENT POUR	ReH ≤ 460 MPa (67 ksi) ISO 15608: 1.2 (275 < ReH < 360 MPa), 1.3 (ReH > 360 MPa < 460 MPa) 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, 1.1138, 1.5419, 1.8948, 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 10Ni14, 12Ni14, 11MnNi5-3, 13MnNi6-3 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 AH32, AH36, AH40; DH32, DH36, DH40; EH32, EH36, EH40; FH32, FH36, FH40 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, alform plate 460M; durostat 400, 450, durostat B2							
AGRÉMENTS	CE							
POSITIONS DE SOUDAGE								
ANALYSE CHIMIQUE TYPIQUE DU MÉTAL D'APPORT (%)	C	Si		Mn		Ni		
	0.1	0.5		1.05		2.45		
PROPRIÉTÉS MÉCANIQUES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Impact Energy (J) ISO-V			Hardness
	As Welded	480	580	28	-40°C	-60°C	-80°C	HRc
					100	60	47	
ETUVAGE	Not required							
GAS ACC. EN ISO 14175	I1							



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SG NI2,5 TIG 1,6 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663405784
SG NI2,5 TIG 2,0 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663405791
SG NI2,5 TIG 2,4 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663405807
SG NI2,5 TIG 3,2 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663405814