



CEWELD SG Ni2,5 Tig

TYPE	Tig-rod for extra low temperature applications.(46 6Ni2, 80S Ni2)							
APPLICATIONS	CEWELD® SG Ni2,5 Tig was developed for fine-grain steels and low-temperature steels. Typical applications are welding boilers for liquid petrol gas (LPG). For cryogenic construction steels and Ni bearing low temperature steels.							
PROPERTIES	CEWELD® SG Ni2.5 Tig is a copper-coated, Ni-alloyed (2.4% Ni) solid wire for low temperature steels with a minimum yield strength > 470 Mpa. The wire offers excellent impact strength 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						
SUITABLE FOR	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							
APPROVALS	CE							
WELDING POSITIONS								
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si		Mn		Ni		
	0.1	0.5		1.05		2.45		
MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness
	As Welded	480	580	28	-40°C	-60°C	-80°C	HRc
					100	60	47	
REDRYING	Not required							
GAS ACC. EN ISO 14175	I1							



CEWELD SG Ni2,5 Tig

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