



CEWELD SG 1

TYPE	Copper coated welding wire developed for MAG welding of un and -low alloyed steels with low silicon and manganese content.																	
APPLICATIONS	CEWELD® SG 1 is a GMAW wire for joining and surfacing unalloyed and low-alloy structural steels. Typical areas of application are shipbuilding, tank and plant construction																	
PROPERTIES	CEWELD® SG 1 is extremely easy to weld with excellent welding properties. Due to its low silicon content, it is suitable for welding galvanized sheet metal or weld seams that subsequently have to be galvanized. Can be welded with Co2 and mixed gas.																	
CLASSIFICATION	AWS	A 5.18: ER 70S-3																
	EN ISO	14341-A: G 42 4 M21 2Si																
	F-nr	6																
	FM	1																
SUITABLE FOR	Rp< 420 MPa (60ksi) ISO 15608: 1.1(ReH < 275 MPa), 1.2 (275 < ReH < 360 MPa), 1.3 (ReH > 360 MPa < 420 MPa) 1.0035, 1.0038, 1.0039, 1.0044, 1.0112, 1.0116, 1.0130, 1.0145, 1.0253, 1.0254, 1.0255, 1.0258, 1.0259, 1.0319, 1.0345, 1.0345, 1.0345, 1.0348, 1.0352, 1.0418, 1.0420, 1.0425, 1.0425, 1.0425, 1.0451, 1.0452, 1.0453, 1.0457, 1.0459, 1.0460, 1.0461, 1.0486, 1.0490, 1.0491, 1.0619, 1.1100, 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, 1.8902, 1.8912, 1.8932 10Ni14, 12Ni14, 13MnNi6-3, 15NiMn6, S235JR-S355JR, S235JO-S355JO, P195TR1-P265TR1, P195GH-P265GH, L245NB-L360NB, L245MB-L360MB, L415NB, L415MB, WStE 380, WStE 420, S420NL A, B, D, E, A 32-E 36 ASTM A 105, A 106, Gr. A, B; A 283 Gr. A, C; A 285 Gr. A, B, C; A 501, Gr. B; A 573, Gr. 58, 65, 70; A 633, Gr. A, C; A 711 Gr. 1013; API 5 L Gr. B, X42, X52, X60 Domex 315-420MC,MC Plus, ML																	
APPROVALS	CE																	
WELDING POSITIONS																		
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table><tr><td>C</td><td>Si</td><td>Mn</td></tr><tr><td>0.07</td><td>0.5</td><td>1.3</td></tr></table>					C	Si	Mn	0.07	0.5	1.3							
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MECHANICAL PROPERTIES	<table><tr><th rowspan="2">Heat Treatment</th><th rowspan="2">R_{P0.2} (MPa)</th><th rowspan="2">R_m (MPa)</th><th rowspan="2">A₅ (%)</th><th>Impact Energy (J) ISO-V</th><th rowspan="2">Hardness</th></tr><tr><th>-40°C</th></tr><tr><td>As Welded</td><td>467</td><td>553</td><td>26</td><td>85</td><td>HRc</td></tr></table>					Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V	Hardness	-40°C	As Welded	467	553	26	85	HRc
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				-40°C														
As Welded	467	553	26	85	HRc													
REDRYING	Not required																	
GAS ACC. EN ISO 14175	M20, M21, C1																	



CEWELD SG 1

SG 1 0,8MM

Packaging	KG/unit	EanCode
D-100	1	8720663404817
D-300	15	8720663404824

SG 1 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663404848
D-100	1	8720663404831
Drum	250	8720663404855

SG 1 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663404862
Drum	250	8720663404879

SG 1 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663404886