



# CEWELD SG 2 Tig

|                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                         |                      |                    |                         |       |       |          |
|---------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------|----------------------|--------------------|-------------------------|-------|-------|----------|
| TYPE                                              | Copper coated welding rod for welding un and -low alloyed steels upto 420 MPa yield strength.( ER70S6, 3Si1)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                         |                      |                    |                         |       |       |          |
| APPLICATIONS                                      | CEWELD® SG2 Tig is a Tig-Rod for joining and surfacing unalloyed and low-alloy structural steels. Typical in Shipbuilding, piping, bridges, repair, construction, car-plate welding etc. Suitable for sour gas applications due to the very low P/S/Ni content                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                         |                      |                    |                         |       |       |          |
| PROPERTIES                                        | CEWELD® SG2 Tig is extreme easy to weld with excellent welding properties. High world wide excepted quality with controlled cast en helix for semi and or semi-automatic applications.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                         |                      |                    |                         |       |       |          |
| CLASSIFICATION                                    | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | A 5.18: ER 70S-6        |                      |                    |                         |       |       |          |
|                                                   | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | 636-A: W 46 5 3Si1      |                      |                    |                         |       |       |          |
|                                                   | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | 1.5125                  |                      |                    |                         |       |       |          |
|                                                   | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | 6                       |                      |                    |                         |       |       |          |
|                                                   | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | 1                       |                      |                    |                         |       |       |          |
| SUITABLE FOR                                      | <p><b>Rp&lt; 420 MPa (60ksi) ISO 15608: 1.1( ReH &lt; 275 MPa ), 1.2 (275 &lt; ReH &lt; 360 MPa), 1.3 (ReH &gt; 360 MPa &lt; 420 MPa)</b></p> <p>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</p> <p>10Ni14, 12Ni14, 13MnNi6-3, 15NiMn6,<br/>S235JR-S355JR, S235JO-S355JO, P195TR1-P265TR1, P195GH-P265GH, L245NB-L360NB, L245MB-L360MB, L415NB, L415MB, WStE 380, WStE 420, S420NL</p> <p>A, B, D, E, A 32-E 36</p> <p><b>ASTM</b> 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;</p> <p><b>API</b> 5 L Gr. B, X42, X52, X60</p> <p>Domex 315-420MC,MC Plus, ML</p> |                         |                      |                    |                         |       |       |          |
| APPROVALS                                         | TÜV: (19806), CE                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                         |                      |                    |                         |       |       |          |
| WELDING POSITIONS                                 | <div><div>PA</div><div>PB</div><div>PC</div><div>PD</div><div>PE</div><div>PF</div><div>PG</div></div>                                                                                                                                                                                                                                                                                                                                                                              |                         |                      |                    |                         |       |       |          |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                         | Si                   |                    | Mn                      |       |       |          |
|                                                   | 0.08                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                         | 0.85                 |                    | 1.45                    |       |       |          |
| 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 |
|                                                   | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | 450                     | 560                  | 24                 | RT                      | -40°C | -50°C | HRc      |
|                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                         |                      |                    | 200                     | 150   | 60    |          |
| REDRYING                                          | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                         |                      |                    |                         |       |       |          |
| GAS ACC. EN ISO 14175                             | I1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                         |                      |                    |                         |       |       |          |



# CEWELD SG 2 Tig

SG 2 TIG 0,8 X 1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663411235 |

SG 2 TIG 1,0 X 1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663411242 |

SG 2 TIG 1,2 X 1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663411259 |

SG 2 TIG 1,6 X 1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663411266 |

SG 2 TIG 2,0 X 1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663411280 |

SG 2 TIG 2,4 X 1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663411297 |

SG 2 TIG 3,0 X 1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663411303 |

SG 2 TIG 3,2 X 1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663411310 |

SG 2 TIG 4,0 X 1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663411327 |

SG 2 TIG 5,0 X 1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663411334 |