



CEWELD G3

TYPE	Copper-coated filler metal for gas welding (0,5% Ni)				
TOEPASSINGEN	Gas welding of steels that require good impact properties at low temperature.				
EIGENSCHAPPEN	Excellent impact properties at low temperatures due to the addition of Nickel with increased yield strenght.				
CLASSIFICATIE	AWS	A 5.2: R60			
	EN ISO	20378: O III			
	F-nr	6			
	FM	1			
GESCHIKT VOOR	Re ≤ 300 MPa (55 ksi) ISO 15608: 1.1(ReH < 275 MPa) 1.2 (275 < ReH < 300 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, 1.0427, 1.0432, 1.0446, 1.0451, 1.0452, 1.0453, 1.0457, 1.0459, 1.0460, 1.0460, 1.0461, 1.0486, 1.0490, 1.0491, 1.0505, 1.0545, 1.0546, 1.0562, 1.0566, 1.0570, 1.0578, 1.0581, 1.0582, 1.1138, 1.5419, 1.8948 C 22.8 S1, S185, S235JRG2, S235JR S235JRH, S275JR, P235S, S235J2G3, P265S, S275J2, P235TR1, P235TR2, P265TR1, P265TR2, P235GH, P235GH, P235GH, P195GH, P245GH, L245ME, GE200, P265GH, P265GH, P265GH, C 22.3, C 21 , GE240, P215NL, P 250, P255QL, P265NL, L245NE, C 22.8, P250GH, P275N, S275N, S275NL, GP240GH, P275SL, 21 Mn 6, StE 320.7, St 52.0, P280GH, (X42ME) L290ME, P305GH, P355GH, P295GH, L290NE, S355N, S355NL, P355N, P355NL1, S355J2G3, G21Mn5, G20Mo5, X52QE, ASTM: A 105, A 27 u. A36 Gr. all; A214; A 242 Gr.1-5; A266 Gr. 1, 2, 4; A283 Gr. A, B, C, D; A285 Gr. A, B, C; A299 Gr. A, B; A328; A366; A515 Gr. 60, 65, 70; A516 Gr. 55; A570 Gr. 30, 33, 36, 40, 45; A 572 Gr. 42, 50; A606 Gr. Alle; A607 Gr. 45; A656 Gr. 50, 60; A668 Gr. A, B; A907 Gr. 30, 33, 36, 40; A841; A851 Gr. 1, 2; A935 Gr.45; A936 Gr. 50; API 5 L Gr. B, X42-X52				
GOEDKEURINGEN	CE				
LASPOSITIES					
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	Ni	
	0.1	0.1	1.1	0.4	
MECHANISCHE WAARDEN	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V
	As Welded	340	470	20	RT
					65
					Hardness
					HRc
HERDROGEN	Not required				
GAS ACC. EN ISO 14175	None				