



# CEWELD SG 2.0

|                                                        |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                                   |                      |                    |                         |          |
|--------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------|----------------------|--------------------|-------------------------|----------|
| TYPE                                                   | Fil à souder R 70S-6 pour le soudage d'aciers non alliés et faiblement alliés jusqu'à une limite d'élasticité de 420 MPa.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                                   |                      |                    |                         |          |
| APPLICATIONS                                           | Construction navale, pipelines, ponts, réparation, construction, soudures à plat, soudage de tôles automobiles, etc.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                                   |                      |                    |                         |          |
| PROPRIÉTÉS                                             | Fil d'apport massif enrobé de cuivre présentant d'excellentes propriétés de soudage. CEWELD SG 2.0 est extrêmement facile à souder avec un arc très stable et doux. Faible formation de projections. Haute qualité avec moulage et hélice contrôlés. Excellent pour les applications de soudage semi-automatiques et entièrement automatiques.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                                   |                      |                    |                         |          |
| CLASSIFICATION                                         | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | A 5.18: ER 70S-6                                  |                      |                    |                         |          |
|                                                        | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | 14341-A: G 42 4 M21 3Si1, 14341-A: G 42 3 C1 3Si1 |                      |                    |                         |          |
|                                                        | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | 1.5125                                            |                      |                    |                         |          |
|                                                        | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | 6                                                 |                      |                    |                         |          |
|                                                        | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | 1                                                 |                      |                    |                         |          |
| CONVIENT POUR                                          | <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><br>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<br>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<br>A, B, D, E, A 32-E 36<br><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;<br><b>API</b> 5 L Gr. B, X42, X52, X60<br>Domex 315-420MC,MC Plus, ML |                                                   |                      |                    |                         |          |
| AGRÉMENTS                                              | CE, TÜV: (20180)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                   |                      |                    |                         |          |
| POSITIONS DE SOUDAGE                                   | <div><div></div><div></div><div></div><div></div><div></div><div></div><div></div></div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                                   |                      |                    |                         |          |
| ANALYSE CHIMIQUE<br>TYPIQUE DU MÉTAL DE<br>SOUDURE (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | Si                                                | Mn                   | P                  | S                       |          |
|                                                        | 0.07                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | 0.85                                              | 1.45                 | 0.015              | 0.015                   |          |
| PROPRIÉTÉS MÉCANIQUES                                  | 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                                               | 550                  | 30                 | -40°C                   |          |
|                                                        |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                                   |                      |                    | 80                      | HRc      |
| ETUVAGE                                                | non requis                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                                                   |                      |                    |                         |          |
| GAS ACC. EN ISO 14175                                  | M21, C1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                   |                      |                    |                         |          |



# CEWELD SG 2.0

## SG 2.0 0,8MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 16      | 8720682051245 |
| Drum      | 250     | 8720682051252 |

## SG 2.0 1,0MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 16      | 8720663424655 |
| Drum      | 250     | 8720663424662 |

## SG 2.0 1,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 16      | 8720663424679 |
| Drum      | 250     | 8720663424686 |