


CATEGORY	GMAW Solid wires
TYPE	Solid welding wire for fine grain steels and cold-tough steels.
APPLICATIONS	Offshore drilling equipment, crane building, pipeline, platforms, Vessel, riser piping etc.
PROPERTIES	CEWELD SG3 NiMo1 is a 0.9% Ni-alloyed, high manganese containing, copper-coated, solid wire for the GMAW/GTAW of low-temperature, fine-grained steels suitable for NACE requirements. The deposit provides good impact toughness down to -50°C and is especially suitable for use in the offshore industry such as riser pipes that often are heat treated after welding..

CLASSIFICATION	AWS	A 5.28: ER 90S-G
	EN ISO	16834-A: G 62 6 M21 Mn3Ni1Mo
	F-nr	6
	FM	2

SUITABLE FOR	P460NL1, P460ML1, S460Q-S550Q, S460QL-S550QL, P460Q-P500Q, P460QL1- 500QL1. 15NiCuMoNb5-6-4 (1.6368) ASTM: A182 grade F36, A335 grade P36, A533, A537, X70, X80, 4130, 4140, 8630 25CrMo4, 42CrMo4
--------------	--

APPROVALS	CE
-----------	----

WELDING POSITIONS:	
--------------------	--

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)							
C	Si	Mn	P	S	Ni	Mo	
0.12	0.5	1.75	0.01	0.01	0.9	0.55	

ALL WELD MECHANICAL PROPERTIES				
Heat Treatment	R _{p0.2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V -50°C
As Welded /	640	740	20	100

WELDING PARAMETERS / PACKING					
WELDING PARAMETERS	WELDING PARAMETERS	WELDING PARAMETERS	PACKING	PACKING	PACKING
D (MM)	VOLTAGE (V)	CURRENT (A)	SPOOLING TYPE	KG / SPOOL	KG / PALLET
0,8	16-22	40-170	D-200 / K-300 / DRUM	5 / 15 / 250	1000 / 1080 / 1000
1,0	18-28	80-280	D-200 / K-300 / DRUM	5 / 15 / 250	1000 / 1080 / 1000
1,2	20-33	120-350	D-200 / K-300 / DRUM	5 / 15 / 250	1000 / 1080 / 1000

REDRYING TEMPERATURE	Not required
----------------------	--------------

GAS ACCORDING EN 14175	M21
------------------------	-----