



# CEWELD SG NiMo1

|                                                      |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                            |                      |                    |                         |       |          |
|------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------|----------------------|--------------------|-------------------------|-------|----------|
| TYPE                                                 | Solid welding wire for fine grain steels and cold-tough steels.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                            |                      |                    |                         |       |          |
| APPLICATIONS                                         | Offshore drilling equipment, crane building, pipeline, platforms, Vessel etc.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                            |                      |                    |                         |       |          |
| PROPRIÉTÉS                                           | SG NiMo1 is a 0.9% Ni-alloyed (ER80S-Ni1), copper-coated, solid wire for the GMAW/GTAW of low-temperature, fine-grained steels. The deposit provides good impact toughness down to -50°C and is especially suitable for use in the offshore industry.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |                            |                      |                    |                         |       |          |
| CLASSIFICATION                                       | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | A 5.28: ER 80S-Ni1         |                      |                    |                         |       |          |
|                                                      | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | 14341-A: G 50 5 M21 Z 3Ni1 |                      |                    |                         |       |          |
|                                                      | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | 6                          |                      |                    |                         |       |          |
|                                                      | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | 1                          |                      |                    |                         |       |          |
| CONVIENT POUR                                        | <b>ReH ≤ 500 MPa ISO 15608: 1.2 (275 &lt; ReH &lt; 360 MPa), 1.3 (ReH &gt; 360 MPa &lt; 500 MPa)</b><br>1.8900, 1.8901, 1.8902, 1.8903, 1.8905, 1.8907, 1.8910, 1.8912, 1.8915, 1.8917, 1.8930, 1.8932, 1.8935, 1.8937, 1.8970, 1.8971, 1.8972, 1.8973, 1.8975<br>S460N, S420N, S460NL, P460N, StE 420, StE 460, StE 500, TSStE 380, S420NL, P460NL1, P420NH, P460NH, TSStE 420, TSStE 460, TSStE 500, WStE 380, WStE 420, WStE 460, WStE 500, StE 385.7, StE 385.7 TM, StE 415, L485ME, 11MnNi5-3, 13MnNi6-3<br>ASTM A 203 Gr. D, E; A 350 Gr. LF1, LF2, LF3; A 420 Gr. WPL3, WPL6; A 516 Gr. 60, 65, 70; A 572 Gr. 42, 50, 55, 60, 65; A 633 Gr. A, D, E; A 662 Gr. A, B, C; A 707 Gr. L1, L2, L3; A 738 Gr. A; A 841 A, B, C; API 5 L X52, X60, X65, X52Q, X60Q, X65Q |                            |                      |                    |                         |       |          |
| AGRÉMENTS                                            | CE                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                            |                      |                    |                         |       |          |
| POSITIONS DE SOUDAGE                                 |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                            |                      |                    |                         |       |          |
| ANALYSE CHIMIQUE<br>TYPIQUE DU MÉTAL<br>D'APPORT (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | Si                         | Mn                   | P                  | S                       | Ni    | Mo       |
|                                                      | 0.1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | 0.5                        | 1.2                  | 0.015              | 0.015                   | 0.95  | 0.18     |
| 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 |
|                                                      |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                            |                      |                    | RT                      | -50°C |          |
|                                                      | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | 500                        | 620                  | 25                 | 150                     | 100   | HRc      |
| ETUVAGE                                              | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                            |                      |                    |                         |       |          |
| GAS ACC. EN ISO 14175                                | M21                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                            |                      |                    |                         |       |          |



# CEWELD SG NiMo1

SG NIM01 0,8MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| D-200     | 5       | 8720663405654 |

SG NIM01 1,0MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663416759 |

SG NIM01 1,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663416780 |