

## SG3 NiMo1

**CATEGORY** GMAW-GTAW 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** 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	14341-A: G 50 7 M21 4Mo
DIN	8575:

**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 approved

**WELDING POSITIONS:**



**WELD METAL WEIGHT %**

C	Mn	Si	Cr	Ni	Mo
0.12	1.75	0.20	-	0,9	0.55

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				+20°C	-40°C	-50°C	
AW	>620	>740	>20	150		>100	

AW: as welded

**WELDING PARAMETERS / PACKING**

Welding Parameters			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 ACC. EN ISO 14175:** M21