



CEWELD S4

TYPE	Solid wire for submerged arc welding
ANWENDUNGEN	Pressure vessels, shipbuilding, steel structures
EIGENSCHAFTEN	High Mn alloyed welding wire that can be used in combination with the fluxes FL 155 or FL 180
KLASSIFIKATION	AWS EN ISO W.Nr. F-nr FM A 5.23: EH14 14171-A: S4 1.5086 6 1
GEEIGNET FÜR	S275JR - S355JO, E335, P285NH, P310GH, S355J0Cu, Ship construction grades A - E, Fine grain steels up-to P460N

ZULASSUNGEN

CE

SCHWEISSPOSITIONEN



TYPISCHE CHEMISCHE ANALYSE DES FÜLLMETALLS (%)	C	Si	Mn	Cr	Ni	Mo	Cu
	0.12	0.08	1.9	0.04	0.05	0.01	0.14

MECHANISCHE GÜTEWERTE	Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness
					RT	-20°C	-40°C	
	As Welded	490	600	26	120	100	85	HRc

RÜCKTROCKNUNG

Not required

GAS ACC. EN ISO 14175