

# CEWELD S1

**TYPE** Solid wire for welding non-alloyed steel

**ANWENDUNGEN** Shipbuilding, pressure vessels, steel structures.

**EIGENSCHAFTEN** Coppered solid wire for SAW welding in combination with our FL 180 flux

**KLASSIFIKATION**

|        |                            |
|--------|----------------------------|
| AWS    | A 5.23: EL12, A 5.17: EL12 |
| EN ISO | 14171-A: S1                |
| F-nr   | 6                          |
| FM     | 1                          |

**GEEIGNET FÜR** Unalloyed steels: St 33 – St 52 Ship building: A, E, AH, EH Boiler steels: H1-H111, 17Mn4, Pipe steels: St 37.0/4 – St 52.0/4 Fine-grain steels: StE 255 – StE 420

**ZULASSUNGEN** CE

**SCHWEISSPOSITIONEN**



**TYPISCHE CHEMISCHE  
ANALYSE DES  
FÜLLMETALLS (%)**

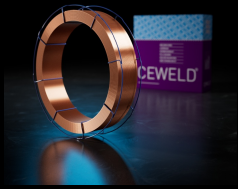
| C   | Si  | Mn  | P     | S    |
|-----|-----|-----|-------|------|
| 0.1 | 0.5 | 0.5 | 0.015 | 0.02 |

**MECHANISCHE GÜTEWERTE**

| Heat<br>Treatment | R <sub>p0,2</sub><br>(MPa) | R <sub>m</sub><br>(MPa) | A <sub>5</sub><br>(%) | Impact Energy (J) ISO-V | Hardness |
|-------------------|----------------------------|-------------------------|-----------------------|-------------------------|----------|
|                   |                            |                         |                       | 0°C                     |          |
| As Welded         | 410                        | 530                     | 26                    | 60                      | HRc      |

**RÜCKTROCKNUNG** Not required

**GAS ACC. EN ISO 14175**



# CEWELD S1

S1 2,4MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| K-415     | 25      | 8720663404251 |

S1 3,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| K-415     | 25      | 8720663404268 |