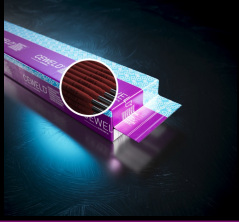


CEWELD E 1000 S

TYPE	Universal rutile electrode for all positions. (Type E 6013, E42 0)								
APPLICATIONS	CEWELD® E 1000 S is a medium thick coated electrode suitable for general construction and offers a very smooth seam surface. Trucks, trailers, wagons, shipbuilding, yacht building, root runs in pipe welding, repair welding etc.								
PROPERTIES	CEWELD® E 1000 S is suitable for all positions; 2,5 mm can even be used in vertical down position. Medium fast freezing weld metal makes this electrode excellently suitable for root runs in vertical up position in pipe welding. The slag is self detaching and the special red coating was developed to offer high resistance against moisture pick up.								
CLASSIFICATION	AWS	A 5.1: E 6013							
	EN ISO	2560-A: E 42 0 RR 12							
	F-nr	1							
	FM	1							
SUITABLE FOR	Rp< 420 MPa (60ksi) ISO 15608: 1.1(ReH < 275 MPa), 1.2 (275 < ReH < 360 MPa), 1.3 (ReH > 360 MPa < 420 MPa) 1.0035, 1.0038, 1.0039, 1.0044, 1.0112, 1.0116, 1.0130, 1.0145, 1.0253, 1.0254, 1.0255, 1.0258, 1.0259, 1.0319, 1.0345, 1.0345, 1.0345, 1.0348, 1.0352, 1.0418, 1.0420, 1.0425, 1.0425, 1.0425, 1.0451, 1.0452, 1.0453, 1.0457, 1.0459, 1.0460, 1.0460, 1.0461, 1.0486, 1.0490, 1.0491, 1.0619, 1.1100, 1.0409, 1.0421, 1.0426, 1.0429, 1.0430, 1.0436, 1.0473, 1.0481, 1.0482, 1.0484, 1.0505, 1.0545, 1.0546, 1.0562, 1.0566, 1.0570, 1.0578, 1.0581, 1.0582, 1.8902, 1.8912, 1.8932 S235JR-S355JR, S235JO-S355JO, P195TR1-P265TR1, P195GH-P265GH, L245NB-L360NB, L245MB-L360MB, L415NB, L415MB, WStE 380, WStE 420, S420NL A, B, D ASTM A 106, Gr. A, B; A 283 Gr. A, C; A 285 Gr. A, B, C; A 501, Gr. B; A 573, Gr. 58, 65, 70; A 633, Gr. A, C; A 711 Gr. 1013; API 5 L Gr. B, X42, X52, X60, (Root X 80)								
APPROVALS	CE								
WELDING POSITIONS									
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	Cr	Ni	Mo	V	Cu	Nb
	0.09	0.45	0.5	0.05	0.06	0.02	0.02	0.1	0.01
MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness	
					0°C				
	As Welded	450	560	24	60			HRc	
REDRYING	140°C / 1 hr								
CURRENT TYPE	AC, DC-								
GAS ACC. EN ISO 14175	None								



CEWELD E 1000 S

E 1000 S 2,5 X 350MM

Packaging	KG/unit	EanCode
Vacuum	2,0	8720663400215

E 1000 S 3,2 X 350MM

Packaging	KG/unit	EanCode
Vacuum	2,2	8720663400222

E 1000 S 4,0 X 350MM

Packaging	KG/unit	EanCode
Vacuum	2,0	8720663400239