



CEWELD GALVA

TYPE	Ultra low alloyed electrode for welding Armco steels																
APPLICATIONS	Joining steels that require either low yield strength and or welding kettle steels used in galvanising plants to prevent Zn sticking on the surface.																
PROPERTIES	Crack resistant weld metal conditioned by the Acid type of slag. Low spatter loss, easy slag removal. Well suited for joining and rebuilding with extreme low Carbon, Silicon and Manganese content in the weld deposit.																
CLASSIFICATION	AWS EN ISO F-nr FM	A 5.1: E 6013 2560-A: E 38 RA 12 2 1															
SUITABLE FOR	Base materials Unalloyed steels Thin steels	EN St 33 to St 42.3 1623/1	W.Nr 1.0035 til 1.0136, 1.1013														
APPROVALS																	
WELDING POSITIONS	PA PB PF																
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C 0.03	Si 0.15	Mn 0.2														
MECHANICAL PROPERTIES	<table><tr><th rowspan="2">Heat Treatment</th><th rowspan="2">R_{p0,2} (MPa)</th><th rowspan="2">R_m (MPa)</th><th rowspan="2">A₅ (%)</th><th>Impact Energy (J) ISO-V</th><th rowspan="2">Hardness</th></tr><tr><th>0°C</th></tr><tr><td>As Welded</td><td>415</td><td>530</td><td>22</td><td>55</td><td>HRc</td></tr></table>	Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V	Hardness	0°C	As Welded	415	530	22	55	HRc			
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		0°C															
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REDRYING	Not required																
GAS ACC. EN ISO 14175																	