



# CEWELD S2Si

**TYPE** Solid wire for submerged arc welding up to 420 MPa yield strength structural steels

**APPLICATIONS** Shipbuilding, piping, root welding, bridges, repair, construction, offshore, etc.

**PROPERTIES** Solid drawn and rolled SAW wire with copper coating for improved current carrying capacity. S2 wire can be used with FL 180, FL188, FL 155 and FL 851 depending on the requirements and application.

**CLASSIFICATION**  
 AWS A 5.17: EM12K, A 5.23: EM12K  
 EN ISO 14171-A: S2Si  
 F-nr 6  
 FM 1

**SUITABLE FOR** A, B, D, E, St 37 - St 52-3, DIN 17 100, H I, H II, 17Mn4, 16Mo5, DIN 17 155, StE 255 - StE 355, DIN 17 102, GS-38, GS-60, DIN 1681, St 35.8, St 45.8, DIN 17 175, St 37.0 - St 52.0, DIN 1626 / 1629, St 37.4 - St 52.4, DIN 1628 / 1630, StE 290.7 TM - StE 360.7 TM, DIN 17 172, X 52

**APPROVALS** CE

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)**

C	Si	Mn	P	S
0.1	0.3	1.1	0.015	0.015

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
				0°C	-20°C	
As Welded	460	600	22	60	50	HRC

**REDRYING** Not required

**GAS ACC.** EN ISO 14175