



CEWELD G4

TYPE	High strength Mn / Mo- alloyed filler metal for flame welding with extreme good flowing properties without spatters during welding.(R60-G, OIV)					
APPLICATIONS	CEWELD® GIV is for Gas-welding of high-temperature low-alloy steels. Fields of application are. Boiler, tank, pipeline, equipment and reactor construction.Finegrain and creep resistant molybdenum containing steels.					
PROPERTIES	CEWELD® GIV is a high-strength manganese-molybdenum alloyed filler metal for flame welding with excellent flow properties and minimal spatter during welding. It has excellent mechanical strength due to the addition of molybdenum, making it ideal for heat-resistant applications up to 500°C. The deposit is homogeneous and suitable for heat treatment (PWHT).					
CLASSIFICATION	AWS EN ISO F-nr FM	A 5.2: R60-G 20378: O IV 6 1				
SUITABLE FOR	Typ 0,5Mo ≤ 460 MPa, ISO 15608: 1.2, 1.3 1.5415, 1.0481, 1.0482 15Mo3, 16Mo3 , 20MnMoNi4-5, 15NiCuMoNb5, S235JR-S355JR, S235JO-S355JO, S450JO, S235J2-S355J2, S275N-S460N, S275M-S460M, P235GH-P355GH, P355N, P285NH-P460NH, P195TR1-P265TR1, P195TR2-P265TR2, P195GH-P265GH, L245NB-L415NB, L450QB, L245MB-L450MB, GE200-GE300 ASTM: A 29 Gr. 1013, 1016; A 106 Gr. C; A, B; A 182 Gr. F1; A 234 Gr. WP1; A 283 Gr. B, C, D; A 335 Gr. P1; A 501 Gr. B; A 533 Gr. B, C; A 510 Gr. 1013; A 512 Gr. 1021, 1026; A 513 Gr. 1021, 1026; A 516 Gr. 70; A 633 Gr. C; A 678 Gr. B; A 709 Gr. 36, 50; A 711 Gr. 1013; API 5 L B, X42, X52, X60, X65					
APPROVALS	CE					
WELDING POSITIONS						
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	Mo		
	0.12	0.2	1.1	0.5		
MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V	Hardness
	As Welded	350	500	22	RT	
					60	HRc
REDRYING	Not required					
GAS ACC. EN ISO 14175	None					