



CEWELD GALVA

TYPE Ultra low alloyed electrode for welding Armco steels

TOEPASSINGEN Joining steels that require either low yield strength and or welding kettle steels used in galvanising plants to prevent Zn sticking on the surface.

EIGENSCHAPPEN 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.

CLASSIFICATIE

AWS	A 5.1: E 6013
EN ISO	2560-A: E 38 RA 12
F-nr	2
FM	1

GESCHIKT VOOR

Base materials	EN	W.Nr
Unalloyed steels	St 33 to St 42.3	1.0035 til 1.0136, 1.1013
Thin steels	1623/1	

GOEDKEURINGEN

LASPOSITIES



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn
0.03	0.15	0.2

MECHANISCHE WAARDEN

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

HERDROGEN Not required

GAS ACC. EN ISO 14175