



CEWELD S4

TYPE Solid wire for submerged arc welding

ANWENDUNGEN Pressure vessels, shipbuilding, steel structures

EIGENSCHAFTEN High Mn alloyed welding wire that can be used in combination with the fluxes FL 155 or FL 180

KLASSIFIKATION

AWS	A 5.23: EH14
EN ISO	14171-A: S4
W.Nr.	1.5086
F-nr	6
FM	1

GEEIGNET FÜR S275JR - S355JO, E335, P285NH, P310GH, S355J0Cu, Ship construction grades A - E, Fine grain steels up-to P460N

ZULASSUNGEN CE

SCHWEISSPOSITIONEN



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	Cr	Ni	Mo	Cu
0.12	0.08	1.9	0.04	0.05	0.01	0.14

MECHANISCHE GÜTEWERTE

Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness
				RT	-20°C	-40°C	
As Welded	490	600	26	120	100	85	HRc

RÜCKTROCKNUNG Not required

GAS ACC. EN ISO 14175