



# CEWELD S1

<b>TYPE</b>	Solid wire for welding non-alloyed steel								
<b>ANWENDUNGEN</b>	Shipbuilding, pressure vessels, steel structures.								
<b>EIGENSCHAFTEN</b>	Coppered solid wire for SAW welding in combination with our FL 180 flux								
<b>KLASSIFIKATION</b>	<table border="0"> <tr> <td>AWS</td> <td>A 5.23: EL12</td> </tr> <tr> <td>EN ISO</td> <td>14171-A: S1</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>1</td> </tr> </table>	AWS	A 5.23: EL12	EN ISO	14171-A: S1	F-nr	6	FM	1
AWS	A 5.23: EL12								
EN ISO	14171-A: S1								
F-nr	6								
FM	1								
<b>GEEIGNET FÜR</b>	Unalloyed steels: St 33 – St 52 Ship building: A, E, AH, EH Boiler steels: HI-HIII, 17Mn4, Pipe steels: St 37.0/4 – St 52.0/4 Fine-grain steels: StE 255 – StE 420								

**ZULASSUNGEN** CE

**SCHWEISSPOSITIONEN**



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

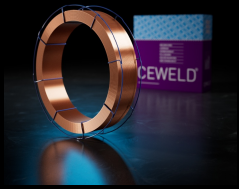
C	Si	Mn	P	S
0.1	0.5	0.5	0.015	0.02

**MECHANISCHE GÜTEWERTE**

Heat Treatment	Rp0,2 (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V	Hardness
				0°C	
As Welded	410	530	26	60	HRc

**RÜCKTROCKNUNG** Not required

**GAS ACC. EN ISO 14175**



# CEWELD S1

S1 2,4MM

Packaging	KG/unit	EanCode
K-415	25	8720663404251

S1 3,2MM

Packaging	KG/unit	EanCode
K-415	25	8720663404268