



CEWELD G4

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|----------------|--|-----|--------------|--------|-------------|------|---|----|---|
| TYPE | High strength Mn / Mo- alloyed filler metal for flame and Tig welding with extreme good flowing properties without spatters during welding. | | | | | | | | |
| ANWENDUNGEN | Finegrain and creep resistant molybdenum containing steels. Suitable for working temperatures up to 500°Celsius. It's suited in trade and industry for welding plates, pipes, boilers and other profiles. | | | | | | | | |
| EIGENSCHAFTEN | High strength Manganese-Molybdenum- alloyed filler metal for flame welding with extreme good flowing properties without spatters during welding. Excelent mechanical strenght due to the addition of Molybdenium.The deposit is homogenous and suitable for heat treatment (PWHT). | | | | | | | | |
| KLASSIFIKATION | <table border="0"> <tr> <td>AWS</td> <td>A 5.2: R60-G</td> </tr> <tr> <td>EN ISO</td> <td>20378: O IV</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>1</td> </tr> </table> | AWS | A 5.2: R60-G | EN ISO | 20378: O IV | F-nr | 6 | FM | 1 |
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GEEIGNET FÜR St37, St42, St35.8, St45.8, 15Mo3, HI, HIII, HII, 17Mn4, 1.0038, 1.0570, 1.0305, 1.0405, 1.5415, 1.0345, 1.0435, 1.0481, 15Mo3, 16Mo3

ZULASSUNGEN CE



| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | C | Si | Mn | Mo |
|---|------|-----|-----|-----|
| | 0.12 | 0.2 | 1.1 | 0.5 |

| MECHANISCHE GÜTEWERTE | Heat Treatment | R _{p0,2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | | Hardness |
|-----------------------|----------------|-------------------------|----------------------|--------------------|-------------------------|--|----------|
| | | | | | RT | | |
| | As Welded | 350 | 500 | 22 | 60 | | HRc |

RÜCKTROCKNUNG Not required

GAS ACC. EN ISO 14175 None