



CEWELD S4

TYPE Solid wire for submerged arc welding

APPLICATIONS Pressure vessels, shipbuilding, steel structures

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

CLASSIFICATION

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

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

APPROVALS CE

WELDING POSITIONS



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

MECHANICAL PROPERTIES

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

REDRYING Not required

GAS ACC. EN ISO 14175