



# CEWELD G2

<b>TYPE</b>	Copper-coated unalloyed rod for gas welding					
<b>APPLICATIONS</b>	Gas welding of unalloyed steels with a minimum tensile strength of 400 MPa					
<b>PROPERTIES</b>	Joints are homogenous and soft, the mechanical treatment is very good					
<b>CLASSIFICATION</b>	AWS	A 5.2: R60				
	EN ISO	20378: O II				
	W.Nr.	1.0494				
	F-nr	6				
	FM	1				
<b>SUITABLE FOR</b>	S185, S235G2T, S235JR S255GT, S235JO, S275JO S275JR, P235G1TH, P255G1TH,P235GH, P265GH, P285NH					
	ASTM: A36, A106 grades A/B/C, A139 grade A, A210 grades A1/C, A216 grades WCA/WCB/WCC, A234 grade WPB					
<b>APPROVALS</b>	CE					
<b>WELDING POSITIONS</b>						
<b>TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)</b>	C	Si	Mn			
	0.1	0.15	1.1			
<b>MECHANICAL PROPERTIES</b>	Heat Treatment	R <sub>p0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V	Hardness
	As Welded	320	450	21	RT	HRC
					50	
<b>REDRYING</b>	Not required					
<b>GAS ACC. EN ISO 14175</b>	None					