



CEWELD G 50

TYPE Copper coated welding wire for MAG welding of un and -low alloyed steels with high yield strength

APPLICATIONS construction, offshore, car-plate welding, shipbuilding, piping, root welding, bridges, repair, etc...

PROPERTIES Extreme easy to weld with excellent welding properties and increased yield strength. High world wide excepted quality with controlled cast and helix for semi and or semi-automatic applications. Weldable with Co2 and Mix gas.

CLASSIFICATION

| | |
|--------|------------------------|
| AWS | A 5.18: ER 70S-6 |
| EN ISO | 14341-A: G 50 5 M 4Si1 |
| W.Nr. | 1.5130 |
| F-nr | 6 |
| FM | 1 |

SUITABLE FOR

Re ≤460 MPa (67 ksi) ISO 15608: 1.1, 1.2, 1.3, 2.1
 S235JR-S355JR, S235JO-S355JO, S450JO, S235J2-S355J2, S275N-S460N, S275M-S460M,
 P235GH-P355GH, P275NL1-P460NL1, P215NL, P265NL, P355N, P285NH-P460NH, P195TR1-
 P265TR1, P195TR2-P265TR2, P195GH-P265GH, L245NB-L415NB, L450QB, L245MB-L450MB,
 GE200-GE240,
 A, B, D, E, A 32-E 36
 ASTM: A 106 Gr. A, B, C; A 181 Gr. 60, 70; A 283 Gr. A, C; A 285 Gr. A, B, C; A 350 Gr. LF1; A 414 Gr.
 A, B, C, D, E, F, G; A 501 Gr. B; A 513 Gr. 1018; A 516 Gr. 55, 60, 65, 70; A 573 Gr. 58, 65, 70; A 588 Gr.
 A, B; A 633 Gr. C, E; A 662 Gr. B; A 711 Gr. 1013; A 841 Gr. A; API 5 L Gr. B, X42, X52, X56, X60, X65

APPROVALS CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

| C | Si | Mn | P | S | Cr | Ni | Mo | Cu | V | Ti+Zr |
|------|-----|------|------|------|------|------|-------|------|-------|-------|
| 0.08 | 0.9 | 1.67 | 0.01 | 0.01 | 0.04 | 0.02 | 0.005 | 0.11 | 0.001 | 0.013 |

MECHANICAL PROPERTIES

| Heat Treatment | R _{P0.2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | | Hardness |
|----------------|-------------------------|----------------------|--------------------|-------------------------|--|----------|
| | | | | -50°C | | |
| As Welded | 560 | 700 | 18 | 60 | | HRc |

REDRYING Not required

GAS ACC. EN ISO 14175 M21



CEWELD G 50

G 50 1,2MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| BS-300 | 15 | 8720663424556 |
| Drum | 250 | 8720663407115 |