



# CEWELD S2 1NiCrMo

**TYPE** Solid wire for submerged arc welding process for welding HSLA structural steels

**APPLICATIONS** Heavy construction, lifting, platforms, jackups, towers, crane building, machinery, riser pipes etc.

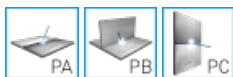
**PROPRIÉTÉS** High strength weld deposit with good post weld heat treatment properties. S2 1NiCrMo can be used in combination with FL 851 and FL 155, both fluxes offer low hydrogen content and excellent weldability in multi layer welding and narrow gap.

**CLASSIFICATION** EN ISO 24598-A: S2 Z 1NiCrMo

**CONVIENT POUR** X80, AISI 4130, 8630, ASME: ASTM A302 Grade B, ASTM A336 Grade F30, ASTM A487 Class 1N, 1Q 2N, 2Q, 4130  
EN: S(P)460-S(P)555

**AGRÉMENTS**

**POSITIONS DE SOUDAGE**



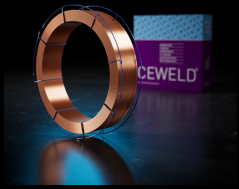
**TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)**

C	Si	Mn	P	S	Cr	Mo	Ni	Cu
0.12	0.27	1.09	0.006	0.005	1.04	0.57	0.92	0.075

**PROPRIÉTÉS MÉCANIQUES**

**ETUVAGE** Not required

**GAS ACC. EN ISO 14175**



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S2 1NICRMO 2,4MM

Packaging	KG/unit	EanCode
K-415	25	8720663404718