



# CEWELD G4

**TYPE** High strength Mn / Mo- alloyed filler metal for flame and Tig welding with extreme good flowing properties without spatters during welding.

**APPLICATIONS** 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.

**PROPRIÉTÉS** 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).

**CLASSIFICATION**

AWS	A 5.2: R60-G
EN ISO	20378: O IV
F-nr	6
FM	1

**CONVIENT POUR** 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

**AGRÉMENTS** CE

**POSITIONS DE SOUDAGE**

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

PROPRIÉTÉS MÉCANIQUES	Heat Treatment	R <sub>p0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V	
					RT	Hardness
	As Welded	350	500	22	60	HRc

**ETUVAGE** Not required

**GAS ACC. EN ISO 14175** None