



CEWELD G1

TYPE	Copper-coated unalloyed rod for gas welding.						
ANWENDUNGEN	Gas welding of unalloyed steels with a minimum tensile strength of 340 MPa. Mainly used for welding plates, pipes and other profiles with low strenght required.						
EIGENSCHAFTEN	Joints are homogenous and soft, the mechanical treatment is very good.						
KLASSIFIKATION	AWS	A 5.2: R45					
	EN ISO	20378: 0 I					
	W.Nr.	1.0324					
	F-nr	6					
	FM	1					
GEEIGNET FÜR	1.0035, 1.0561, 1.0308, 1.0305 S185, S235JR, St33, St52, St35, St35.8, ASTM: A36, A106 grades A/B, A139 grade A, A216 grades WCA/WCB/WCC, A234 grade WPB						
ZULASSUNGEN	CE						
SCHWEISSPOSITIONEN							
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si					
	0.08	0.1					
		Mn					
		0.5					
MECHANISCHE GÜTEWERTE	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
	As Welded	300	400	20	RT	0°C	HRC
					35	30	
RÜCKTROCKNUNG	Not required						
GAS ACC. EN ISO 14175	None						