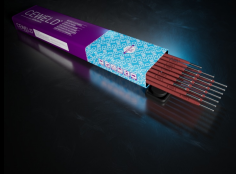


CEWELD E 1000 S

| TYPE | Universal Rutil Stabelektrode für alle Positionen (Typ 6013) | | | | | | | | | | | | | | | | | | |
|---|--|----------------|-------------------------|----------------------|----------------------|-------------------------|--------------------|----------|-------------------------|----|-----------|------|-----|------|------|------|------|-----|------|
| ANWENDUNGEN | CEWELD® E 1000 S ist eine mitteldick umhüllte Elektrode, die sich für allgemeine Konstruktion eignet und eine sehr glatte Nahtoberfläche bietet. Lastkraftwagen, Anhänger, Waggons, Schiffsbau, Yachtbau, Wurzelschweißen von Rohren, Reparaturschweißen usw. | | | | | | | | | | | | | | | | | | |
| EIGENSCHAFTEN | CEWELD® E 1000 S ist für alle Positionen geeignet. Die 2,5 mm Elektrode kann fallend verschweißt werden. Durch das schnell erstarrende Schweißgut eignet sich diese Elektrode hervorragend für Wurzelschweißen in Position PF bei Rohrschweißungen. Die Schlacke ist selbstablösend und die spezielle rote Umhüllung wurde entwickelt, um eine hohe Beständigkeit gegen Feuchtigkeitssaufnahme zu bieten. | | | | | | | | | | | | | | | | | | |
| KLASSIFIKATION | <table border="0"> <tr> <td>AWS</td> <td>A 5.1: E 6013</td> </tr> <tr> <td>EN ISO</td> <td>2560-A: E 42 0 RR 12</td> </tr> <tr> <td>F-nr</td> <td>1</td> </tr> <tr> <td>FM</td> <td>1</td> </tr> </table> | AWS | A 5.1: E 6013 | EN ISO | 2560-A: E 42 0 RR 12 | F-nr | 1 | FM | 1 | | | | | | | | | | |
| AWS | A 5.1: E 6013 | | | | | | | | | | | | | | | | | | |
| EN ISO | 2560-A: E 42 0 RR 12 | | | | | | | | | | | | | | | | | | |
| F-nr | 1 | | | | | | | | | | | | | | | | | | |
| FM | 1 | | | | | | | | | | | | | | | | | | |
| GEEIGNET FÜR | <p>Rp < 420 MPa (60ksi) ISO 15608: 1.1 ReH < 275 MPa, 1.2 275 < ReH < 360 MPa , (1.3 ReH > 360 MPa < 420 MPa) AV max 0°C</p> <p>1.0035, 1.0038, 1.0039, 1.0044, 1.0112, 1.0116, 1.0130, 1.0145, 1.0253, 1.0254, 1.0255, 1.0258, 1.0259, 1.0319, 1.0345, 1.0345, 1.0345, 1.0348, 1.0352, 1.0418, 1.0420, 1.0425, 1.0425, 1.0425, 1.0451, 1.0452, 1.0453, 1.0457, 1.0459, 1.0460, 1.0460, 1.0461, 1.0486, 1.0490, 1.0491, 1.0619, 1.1100, 1.0409, 1.0421, 1.0426, 1.0429, 1.0430, 1.0436, 1.0473, 1.0481, 1.0482, 1.0484, 1.0505, 1.0545, 1.0546, 1.0562, 1.0566, 1.0570, 1.0578, 1.0581, 1.0582, 1.8902, 1.8912, 1.8932 S235JR-S355JR, S235JO-S355JO, P195TR1-P265TR1, P195GH-P265GH, L245NB-L360NB, L245MB-L360MB, L415NB, L415MB, WStE 380, WStE 420, S420NL A, B, D ASTM A 106, Gr. A, B; A 283 Gr. A, C; A 285 Gr. A, B, C; A 501, Gr. B; A 573, Gr. 58, 65, 70; A 633, Gr. A, C; A 711 Gr. 1013; API 5 L Gr. B, X42, X52, X56, X60, X65 (Root X 80)</p> | | | | | | | | | | | | | | | | | | |
| ZULASSUNGEN | CE | | | | | | | | | | | | | | | | | | |
| SCHWEISSPOSITIONEN | | | | | | | | | | | | | | | | | | | |
| TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%) | <table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>V</th> <th>Cu</th> <th>Nb</th> </tr> </thead> <tbody> <tr> <td>0.09</td> <td>0.45</td> <td>0.5</td> <td>0.05</td> <td>0.06</td> <td>0.02</td> <td>0.02</td> <td>0.1</td> <td>0.01</td> </tr> </tbody> </table> | C | Si | Mn | Cr | Ni | Mo | V | Cu | Nb | 0.09 | 0.45 | 0.5 | 0.05 | 0.06 | 0.02 | 0.02 | 0.1 | 0.01 |
| C | Si | Mn | Cr | Ni | Mo | V | Cu | Nb | | | | | | | | | | | |
| 0.09 | 0.45 | 0.5 | 0.05 | 0.06 | 0.02 | 0.02 | 0.1 | 0.01 | | | | | | | | | | | |
| MECHANISCHE GÜTEWERTE | <table border="1"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R_{P0.2} (MPa)</th> <th rowspan="2">R_m (MPa)</th> <th rowspan="2">A₅ (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th colspan="2">0°C</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>450</td> <td>560</td> <td>24</td> <td colspan="2">60</td> <td>HRc</td> </tr> </tbody> </table> | Heat Treatment | R _{P0.2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | | Hardness | 0°C | | As Welded | 450 | 560 | 24 | 60 | | HRc | | |
| Heat Treatment | R _{P0.2} (MPa) | | | | | R _m (MPa) | A ₅ (%) | | Impact Energy (J) ISO-V | | Hardness | | | | | | | | |
| | | 0°C | | | | | | | | | | | | | | | | | |
| As Welded | 450 | 560 | 24 | 60 | | HRc | | | | | | | | | | | | | |
| RÜCKTROCKNUNG | 140°C / 1 hr | | | | | | | | | | | | | | | | | | |
| CURRENT TYPE: | AC, DC- | | | | | | | | | | | | | | | | | | |
| GAS ACC. EN ISO 14175 | None | | | | | | | | | | | | | | | | | | |



CEWELD E 1000 S

E 1000 S 2,5 X 350MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| Vacuum | 2,0 | 8720663400215 |

E 1000 S 3,2 X 350MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| Vacuum | 2,2 | 8720663400222 |

E 1000 S 4,0 X 350MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| Vacuum | 2,0 | 8720663400239 |