



CEWELD S4 MoSi

TYPE Solid wire for submerged arc welding with high Manganese content and 0,5% Mo.

APPLICATIONS Fine grain steels for yield strength applications exceeding 500 MPa. Often used for pipe welding (X70-X80) when Mn. and Si. content is low..

PROPERTIES High Manganese and Silicon content for improved de-oxidation and strength, excellent wetting for increased welding speed with corresponding flux. Suitable fluxes are depending on the weld metal requirements, in most cases CEWELD® FL 155 gives excellent results.

CLASSIFICATION

AWS	A 5.23: EA3K
EN ISO	14341-A: G4Mo
F-nr	6
FM	3

SUITABLE FOR Pipe steels acc. to ISO 3183, EN 10208 and API-5: L360N/X52 to L555Q/X80

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

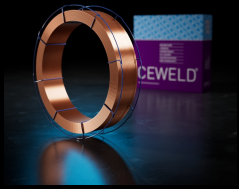
C	Si	Mn	P	S	Mo
0.1	0.7	1.8	0.015	0.015	0.5

MECHANICAL PROPERTIES

Heat Treatment	R _{PO,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V				Hardness
				-20°C	-40°C	0°C	-30°C	
As Welded				60	50	HRc		
580°C±15°C 2h	550	680	20	80	60	50	HRc	

REDRYING Not required

GAS ACC. EN ISO 14175



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Packaging	KG/unit	EanCode
K-415	25	8720663404701