



# CEWELD S2

**TYPE** Solid wire for submerged arc welding up to 420 MPa yield strength structural steels.

**APPLICATIONS** Shipbuilding, piping, root welding, bridges, repair, construction, offshore, etc...

**PROPERTIES** Solid drawn and rolled SAW wire with copper coating for improved current carrying capacity. S2 wire can be used with FL 180, FL188, FL 155 and FL 851 depending on the requirements and application. Approvals in combination with FL 188

**CLASSIFICATION**

AWS	A 5.17: EM12K
EN ISO	14171-A: S2
W.Nr.	1.0494
F-nr	6
FM	1

**SUITABLE FOR** A, B, D, E, St 37 - St 52-3, DIN 17 100, H I, H II, 17Mn4, 16Mo5, DIN 17 155, StE 255 - StE 355, DIN 17 102, GS-38, GS-60, DIN 1681, St 35.8, St 45.8, DIN 17 175, St 37.0 - St 52.0, DIN 1626 / 1629, St 37.4 - St 52.4, DIN 1628 / 1630, StE 290.7 TM - StE 360.7 TM, DIN 17 172, X 52

**APPROVALS** TÜV: 12523, CE, Lloyds, DNV

**WELDING POSITIONS**



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

C	Si	Mn	P	S
0.1	0.12	1.1	0.015	0.015

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V	Hardness
				-30°C	
As Welded	445	560	24	60	HRC

**REDRYING** Not required

**GAS ACC. EN ISO 14175**



# CEWELD S2

## S2 1,6MM

Packaging	KG/unit	EanCode
K-415	27	8720663404350

## S2 2,0MM

Packaging	KG/unit	EanCode
Drum	320	8720663404374
Drum	450	8720663404381
K-415	27	8720663404367