



# CEWELD S4

**TYPE** Solid wire for submerged arc welding

**APPLICATIONS** Pressure vessels, shipbuilding, steel structures

**PROPRIÉTÉS** High Mn alloyed welding wire that can be used in combination with the fluxes FL 155 or FL 180

**CLASSIFICATION**

|        |              |
|--------|--------------|
| AWS    | A 5.23: EH14 |
| EN ISO | 14171-A: S4  |
| W.Nr.  | 1.5086       |
| F-nr   | 6            |
| FM     | 1            |

**CONVIENT POUR** S275JR - S355JO, E335, P285NH, P310GH, S355J0Cu, Ship construction grades A - E, Fine grain steels up-to P460N

**AGRÉMENTS** CE

**POSITIONS DE SOUDAGE**



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

| C    | Si   | Mn  | Cr   | Ni   | Mo   | Cu   |
|------|------|-----|------|------|------|------|
| 0.12 | 0.08 | 1.9 | 0.04 | 0.05 | 0.01 | 0.14 |

**PROPRIÉTÉS MÉCANIQUES**

| Heat Treatment | R <sub>P0.2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |       |       | Hardness |
|----------------|-------------------------|----------------------|--------------------|-------------------------|-------|-------|----------|
|                |                         |                      |                    | RT                      | -20°C | -40°C |          |
| As Welded      | 490                     | 600                  | 26                 | 120                     | 100   | 85    | HRc      |

**ETUVAGE** Not required

**GAS ACC. EN ISO 14175**