



CEWELD S4

TYPE	Solid wire for submerged arc welding							
TOEPASSINGEN	Pressure vessels, shipbuilding, steel structures							
EIGENSCHAPPEN	High Mn alloyed welding wire that can be used in combination with the fluxes FL 155 or FL 180							
CLASSIFICATIE	AWS	A 5.23: EH14						
	EN ISO	14171-A: S4						
	W.Nr.	1.5086						
	F-nr	6						
	FM	1						
GESCHIKT VOOR	S275JR - S355JO, E335, P285NH, P310GH, S355J0Cu, Ship construction grades A - E, Fine grain steels up-to P460N							
GOEDKEURINGEN	CE							
LASPOSITIES	  							
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	
MECHANISCHE WAARDEN	Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness
					RT	-20°C	-40°C	
	As Welded	490	600	26	120	100	85	HRc
HERDROGEN	Not required							
GAS ACC. EN ISO 14175								