



CEWELD G1

TYPE	Copper-coated unalloyed rod for gas welding.						
TOEPASSINGEN	Gas welding of unalloyed steels with a minimum tensile strength of 340 MPa. Mainly used for welding plates, pipes and other profiles with low strenght required.						
EIGENSCHAPPEN	Joints are homogenous and soft, the mechanical treatment is very good.						
CLASSIFICATIE	AWS		A 5.2: R45				
	EN ISO		20378: O I				
	W.Nr.		1.0324				
	F-nr		6				
	FM		1				
GESCHIKT VOOR	Re ≤ 235 MPa (55 ksi) ISO 15608: 1.1(ReH < 235 MPa) 1.0034, 1.0035, 1.0037, 1.0038, 1.0039, 1.0044, 1.0108, 1.0111, 1.0114, 1.0115, 1.0116, 1.0118, 1.0119, 1.0120, 1.0122, 1.0128, 1.0166, 1.0167, 1.0170, 1.0171, 1.0252, 1.0252, 1.0253, 1.0254, 1.0255, 1.0308 E 190, S185, S235JRG2, S235JR S235JRH, P235S, S235J2G3, P235TR1, P235TR2, P235GH, P235GH, P235GH, P195GH, P245GH, L245ME, GE200, C 22.3, C 21 , GE240, P215NL, P275N, S275N, S275NL, GP240GH, P275SL, ASTM: A36, A106 grades A/B, A139 grade A, A216 grades WCA/WCB/WCC, A234 grade WPB						
GOEDKEURINGEN	CE						
LASPOSITIES	      						
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C		Si		Mn		
	0.08		0.1		0.5		
MECHANISCHE WAARDEN	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
					RT	0°C	
	As Welded	300	400	20	35	30	HRc
HERDROGEN	Not required						
GAS ACC. EN ISO 14175	None						