



CEWELD S2Si

TYPE	Solid wire for submerged arc welding up to 420 MPa yield strength structural steels					
TOEPASSINGEN	Shipbuilding, piping, root welding, bridges, repair, construction, offshore, etc.					
EIGENSCHAPPEN	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.					
CLASSIFICATIE	AWS	A 5.17: EM12K, A 5.23: EM12K				
	EN ISO	14171-A: S2Si				
	F-nr	6				
	FM	1				
GESCHIKT VOOR	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					
GOEDKEURINGEN	CE					
LASPOSITIES	 PA  PB  PC					
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	P	S	
	0.1	0.3	1.1	0.015	0.015	
MECHANISCHE WAARDEN	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V	
					0°C	-20°C
	As Welded	460	600	22	60	50
						Hardness
						HRc
HERDROGEN	Not required					
GAS ACC. EN ISO 14175						