



# CEWELD S1

<b>TYPE</b>	Solid wire for welding non-alloyed steel	
<b>TOEPASSINGEN</b>	Shipbuilding, pressure vessels, steel structures.	
<b>EIGENSCHAPPEN</b>	Coppered solid wire for SAW welding in combination with our FL 180 flux	
<b>CLASSIFICATIE</b>	AWS	A 5.23: EL12
	EN ISO	14171-A: S1
	F-nr	6
	FM	1
<b>GESCHIKT VOOR</b>	Unalloyed steels: St 33 – St 52 Ship building: A, E, AH, EH Boiler steels: HI-HIII, 17Mn4, Pipe steels: St 37.0/4 – St 52.0/4 Fine-grain steels: StE 255 – StE 420	

**GOEDKEURINGEN** CE

**LASPOSITIES**



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

C	Si	Mn	P	S
0.1	0.5	0.5	0.015	0.02

**MECHANISCHE WAARDEN**

Heat Treatment	R <sub>p0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V	Hardness
				0°C	
As Welded	410	530	26	60	HRc

**HERDROGEN** Not required

**GAS ACC. EN ISO 14175**



# CEWELD S1

S1 2,4MM

Packaging	KG/unit	EanCode
K-415	25	8720663404251

S1 3,2MM

Packaging	KG/unit	EanCode
K-415	25	8720663404268