



CEWELD S4

TYPE	Solid wire for submerged arc welding		
ANWENDUNGEN	Pressure vessels, shipbuilding, steel structures		
EIGENSCHAFTEN	High Mn alloyed welding wire that can be used in combination with the fluxes FL 155 or FL 180		
KLASSIFIKATION	AWS	A 5.23: EH14	
	EN ISO	14171-A: S4	
	W.Nr.	1.5086	
	F-nr	6	
	FM	1	
GEEIGNET FÜR	S275JR - S355JO, E335, P285NH, P310GH, S355J0Cu, Ship construction grades A - E, Fine grain steels up-to P460N		

ZULASSUNGEN CE

SCHWEISSPOSITIONEN



TYPISCHE CHEMISCHE ANALYSE DES FÜLLMETALLS (%)	C	Si	Mn	Cr	Ni	Mo	Cu
	0.12	0.08	1.9	0.04	0.05	0.01	0.14

MECHANISCHE GÜTEWERTE	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

RÜCKTROCKNUNG Not required

GAS ACC. EN ISO 14175