



CEWELD G1

TYPE	Copper-coated unalloyed rod for gas welding.						
APPLICATIONS	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.						
PROPRIÉTÉS	Joints are homogenous and soft, the mechanical treatment is very good.						
CLASSIFICATION	AWS	A 5.2: R45					
	EN ISO	20378: O I					
	W.Nr.	1.0324					
	F-nr	6					
	FM	1					
CONVIENT POUR	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						
AGRÉMENTS	CE						
POSITIONS DE SOUDAGE							
ANALYSE CHIMIQUE TYPIQUE DU MÉTAL D'APPORT (%)	C		Si		Mn		
	0.08		0.1		0.5		
PROPRIÉTÉS MÉCANIQUES	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
ETUVAGE	Not required						
GAS ACC. EN ISO 14175	None						