



CEWELD G4

TYPE	High strength Mn / Mo- alloyed filler metal for flame and Tig welding with extreme good flowing properties without spatters during welding.					
TOEPASSINGEN	Finegrain and creep resistant molybdenum containing steels. Suitable for working temperatures up to 500°Celsius. It's suited in trade and industry for welding plates, pipes, boilers and other profiles.					
EIGENSCHAPPEN	High strength Manganese-Molybdenum- alloyed filler metal for flame welding with extreme good flowing properties without spatters during welding. Excelent mechanical strenght due to the addition of Molybdenium.The deposit is homogenous and suitable for heat treatment (PWHT).					
CLASSIFICATIE	AWS EN ISO F-nr FM	A 5.2: R60-G 20378: O IV 6 1				
GESCHIKT VOOR	Typ 0,5Mo ≤ 460 MPa, ISO 15608: 1.2, 1.3 1.5415, 1.0481, 1.0482 15Mo3, 16Mo3 , 20MnMoNi4-5, 15NiCuMoNb5, S235JR-S355JR, S235JO-S355JO, S450JO, S235J2-S355J2, S275N-S460N, S275M-S460M, P235GH-P355GH, P355N, P285NH-P460NH, P195TR1-P265TR1, P195TR2-P265TR2, P195GH-P265GH, L245NB-L415NB, L450QB, L245MB-L450MB, GE200-GE300 ASTM: A 29 Gr. 1013, 1016; A 106 Gr. C; A, B; A 182 Gr. F1; A 234 Gr. WP1; A 283 Gr. B, C, D; A 335 Gr. P1; A 501 Gr. B; A 533 Gr. B, C; A 510 Gr. 1013; A 512 Gr. 1021, 1026; A 513 Gr. 1021, 1026; A 516 Gr. 70; A 633 Gr. C; A 678 Gr. B; A 709 Gr. 36, 50; A 711 Gr. 1013; API 5 L B, X42, X52, X60, X65					
GOEDKEURINGEN	CE					
LASPOSITIES						
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	Mo		
	0.12	0.2	1.1	0.5		
MECHANISCHE WAARDEN	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Impact Energy (J) ISO-V	Hardness
	As Welded	350	500	22	RT	HRC
					60	
HERDROGEN	Not required					
GAS ACC. EN ISO 14175	None					