



# 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**



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

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 <sub>P0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	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**