



CEWELD GALVA

TYPE Ultra low alloyed electrode for welding Armco steels

ANWENDUNGEN Joining steels that require either low yield strength and or welding kettle steels used in galvanising plants to prevent Zn sticking on the surface.

EIGENSCHAFTEN Crack resistant weld metal conditioned by the Acid type of slag. Low spatter loss, easy slag removal. Well suited for joining and rebuilding with extreme low Carbon, Silicon and Manganese content in the weld deposit.

KLASSIFIKATION

AWS	A 5.1: E 6013
EN ISO	2560-A: E 38 RA 12
F-nr	2
FM	1

GEEIGNET FÜR

Base materials	EN	W.Nr
Unalloyed steels	St 33 to St 42.3	1.0035 til 1.0136, 1.1013
Thin steels	1623/1	

ZULASSUNGEN

SCHWEISSPOSITIONEN



TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%)

C	Si	Mn
0.03	0.15	0.2

MECHANISCHE GÜTEWERTE

Heat Treatment	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V	Hardness
				0°C	
As Welded	415	530	22	55	HRc

RÜCKTROCKNUNG Not required

GAS ACC. EN ISO 14175