



CEWELD G4

TYPE	High strength Mn / Mo- alloyed filler metal for flame and Tig welding with extreme good flowing properties without spatters during welding.								
ANWENDUNGEN	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.								
EIGENSCHAFTEN	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).								
KLASSIFIKATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.2: R60-G</td> </tr> <tr> <td>EN ISO</td> <td>20378: 0 IV</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>1</td> </tr> </table>	AWS	A 5.2: R60-G	EN ISO	20378: 0 IV	F-nr	6	FM	1
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GEEIGNET FÜR St37, St42, St35.8, St45.8, 15Mo3, HI, HIII, HII, 17Mn4, 1.0038, 1.0570, 1.0305, 1.0405, 1.5415, 1.0345, 1.0435, 1.0481, 15Mo3, 16Mo3

ZULASSUNGEN CE



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	Mo
	0.12	0.2	1.1	0.5

MECHANISCHE GÜTEWERTE	Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
					RT		
	As Welded	350	500	22	60		HRc

RÜCKTROCKNUNG Not required

GAS ACC. EN ISO 14175 None