



CEWELD G2

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|----------------------------------------------------------|-------------------------------------------------------------------------------------------------------|-------------------------|----------------------|--------------------|-------------------------|----------|
| TYPE | Copper-coated unalloyed rod for gas welding | | | | | |
| APPLICATIONS | Gas welding of unalloyed steels with a minimum tensile strength of 400 MPa | | | | | |
| PROPERTIES | Joints are homogenous and soft, the mechanical treatment is very good | | | | | |
| CLASSIFICATION | AWS | A 5.2: R60 | | | | |
| | EN ISO | 20378: O II | | | | |
| | W.Nr. | 1.0494 | | | | |
| | F-nr | 6 | | | | |
| | FM | 1 | | | | |
| SUITABLE FOR | S185, S235G2T, S235JR S255GT, S235JO, S275JO S275JR, P235G1TH, P255G1TH, P235GH, P265GH, P285NH | | | | | |
| | ASTM: A36, A106 grades A/B/C, A139 grade A, A210 grades A1/C, A216 grades WCA/WCB/WCC, A234 grade WPB | | | | | |
| APPROVALS | CE | | | | | |
| WELDING POSITIONS | | | | | | |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | C | Si | Mn | | | |
| | 0.1 | 0.15 | 1.1 | | | |
| MECHANICAL PROPERTIES | Heat Treatment | R _{p0,2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | Hardness |
| | As Welded | 320 | 450 | 21 | RT | HRC |
| | | | | | 50 | |
| REDRYING | Not required | | | | | |
| GAS ACC. EN ISO 14175 | None | | | | | |