



CEWELD G1

TYPE Copper-coated unalloyed rod for gas welding.

APPLICATIONS Gas welding of unalloyed steels with a minimum tensile strength of 340 MPa. Mainly used for welding plates, pipes and other profiles with low strenght required.

PROPERTIES Joints are homogenous and soft, the mechanical treatment is very good.

CLASSIFICATION

AWS	A 5.2: R45
EN ISO	20378: 01
W.Nr.	1.0324
F-nr	6
FM	1

SUITABLE FOR 1.0035, 1.0561, 1.0308, 1.0305
 S185, S235JR, St33, St52, St35, St35.8,
 ASTM: A36, A106 grades A/B, A139 grade A, A216 grades WCA/WCB/WCC, A234 grade WPB

APPROVALS CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn
0.08	0.1	0.5

MECHANICAL PROPERTIES

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				RT	0°C	
As Welded	300	400	20	35	30	HRC

REDRYING Not required

GAS ACC. EN ISO 14175 None