



CEWELD GALVA

TYPE	Ultra low alloyed electrode for welding Armco steels					
APPLICATIONS	Joining steels that require either low yield strength and or welding kettle steels used in galvanising plants to prevent Zn sticking on the surface.					
PROPERTIES	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.					
CLASSIFICATION	AWS	A 5.1: E 6013				
	EN ISO	2560-A: E 38 RA 12				
	F-nr	2				
	FM	1				
SUITABLE FOR	Base materials		EN	W.Nr		
	Unalloyed steels		St 33 to St 42.3	1.0035 til 1.0136, 1.1013		
	Thin steels		1623/1			
APPROVALS						
WELDING POSITIONS	PAPBPF					
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C		Si		Mn	
	0.03		0.15		0.2	
MECHANICAL PROPERTIES	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
REDRYING	Not required					
GAS ACC. EN ISO 14175						