




# CEWELD G2

|   |   |                         |                      |                    |                         |          |
|---|---|-------------------------|----------------------|--------------------|-------------------------|----------|
| TYPE  | Copper-coated unalloyed rod for gas welding   |                         |                      |                    |                         |          |
| ANWENDUNGEN                                       | Gas welding of unalloyed steels with a minimum tensile strength of 400 MPa                            |                         |                      |                    |                         |          |
| EIGENSCHAFTEN                                     | Joints are homogenous and soft, the mechanical treatment is very good                                 |                         |                      |                    |                         |          |
| KLASSIFIKATION                                    | AWS   | A 5.2: R60              |                      |                    |                         |          |
|   | EN ISO  | 20378: O II             |                      |                    |                         |          |
|   | W.Nr.   | 1.0494                  |                      |                    |                         |          |
|   | F-nr  | 6                       |                      |                    |                         |          |
|   | FM  | 1                       |                      |                    |                         |          |
| GEEIGNET FÜR                                      | 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 |                         |                      |                    |                         |          |
| ZULASSUNGEN                                       | CE  |                         |                      |                    |                         |          |
| SCHWEISSPOSITIONEN                                |                      |                         |                      |                    |                         |          |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | C   | Si                      |                      |                    |                         |          |
|   | 0.1   | 0.15                    |                      |                    |                         |          |
|   |   | Mn                      |                      |                    |                         |          |
|   |   | 1.1                     |                      |                    |                         |          |
| MECHANISCHE GÜTEWERTE                             | Heat Treatment  | R <sub>p0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V | Hardness |
|   | As Welded   | 320                     | 450                  | 21                 | RT                      |          |
|   |   |                         |                      |                    | 50                      | HRc      |
| RÜCKTROCKNUNG                                     | Not required  |                         |                      |                    |                         |          |
| GAS ACC. EN ISO 14175                             | None  |                         |                      |                    |                         |          |