



# CEWELD GALVA

**TYPE** Ultra low alloyed electrode for welding Armco steels

**ANWENDUNGEN** Joining steels that require either low yield strength and or welding kettle steels used in galvanising plants to prevent Zn sticking on the surface.

**EIGENSCHAFTEN** 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.

**KLASSIFIKATION**

AWS	A 5.1: E 6013
EN ISO	2560-A: E 38 RA 12
F-nr	2
FM	1

**GEEIGNET FÜR**

<b>Base materials</b>	<b>EN</b>	<b>W.Nr</b>
Unalloyed steels	St 33 to St 42.3	1.0035 til 1.0136, 1.1013
Thin steels	1623/1	

**ZULASSUNGEN**

**SCHWEISSPOSITIONEN**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

C	Si	Mn
0.03	0.15	0.2

**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
				0°C	
As Welded	415	530	22	55	HRc

**RÜCKTROCKNUNG** Not required

**GAS ACC. EN ISO 14175**