



CEWELD S1

TYPE	Solid wire for welding non-alloyed steel					
ANWENDUNGEN	Shipbuilding, pressure vessels, steel structures.					
EIGENSCHAFTEN	Coppered solid wire for SAW welding in combination with our FL 180 flux					
KLASSIFIKATION	AWS	A 5.23: EL12				
	EN ISO	14171-A: S1				
	F-nr	6				
	FM	1				
GEEIGNET FÜR	Unalloyed steels: St 33 – St 52 Ship building: A, E, AH, EH Boiler steels: HI-HIII, 17Mn4, Pipe steels: St 37.0/4 – St 52.0/4 Fine-grain steels: StE 255 – StE 420					
ZULASSUNGEN	CE					
SCHWEISSPOSITIONEN						
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	P	S	
	0.1	0.5	0.5	0.015	0.02	
MECHANISCHE GÜTEWERTE	Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V 0°C	Hardness
	As Welded	410	530	26	60	HRc
RÜCKTROCKNUNG	Not required					
GAS ACC. EN ISO 14175						



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S1 2,4MM

Packaging	KG/unit	EanCode
K-415	25	8720663404251

S1 3,2MM

Packaging	KG/unit	EanCode
K-415	25	8720663404268