



CEWELD G2

TYPE	Copper-coated unalloyed rod for gas welding					
APPLICATIONS	Gas welding of unalloyed steels with a minimum tensile strength of 400 MPa					
PROPERTIES	Joints are homogenous and soft, the mechanical treatment is very good					
CLASSIFICATION	AWS	A 5.2: R60				
	EN ISO	20378: O II				
	W.Nr.	1.0494				
	F-nr	6				
	FM	1				
SUITABLE FOR	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					
APPROVALS	CE					
WELDING POSITIONS						
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn			
	0.1	0.15	1.1			
MECHANICAL PROPERTIES	Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V	Hardness
	As Welded	320	450	21	RT	HRC
					50	
REDRYING	Not required					
GAS ACC. EN ISO 14175	None					