



# CEWELD G1

**TYPE** Copper-coated unalloyed rod for gas welding.

**APPLICATIONS** Gas welding of unalloyed steels with a minimum tensile strength of 340 MPa. Mainly used for welding plates, pipes and other profiles with low strenght required.

**PROPERTIES** Joints are homogenous and soft, the mechanical treatment is very good.

**CLASSIFICATION**

AWS	A 5.2: R45
EN ISO	20378: O I
W.Nr.	1.0324
F-nr	6
FM	1

**SUITABLE FOR** 1.0035, 1.0561, 1.0308, 1.0305  
 S185, S235JR, St33, St52, St35, St35.8,  
 ASTM: A36, A106 grades A/B, A139 grade A, A216 grades WCA/WCB/WCC, A234 grade WPB

**APPROVALS** CE

**WELDING POSITIONS**

**TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)**

C	Si	Mn
0.08	0.1	0.5

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
				RT	0°C	
As Welded	300	400	20	35	30	HRC

**REDRYING** Not required

**GAS ACC. EN ISO 14175** None