



CEWELD S1

TYPE Solid wire for welding non-alloyed steel

APPLICATIONS Shipbuilding, pressure vessels, steel structures.

PROPERTIES Coppered solid wire for SAW welding in combination with our FL 180 flux

CLASSIFICATION

| | |
|--------|--------------|
| AWS | A 5.23: EL12 |
| EN ISO | 14171-A: S1 |
| F-nr | 6 |
| FM | 1 |

SUITABLE FOR 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

APPROVALS CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

| C | Si | Mn | P | S |
|-----|-----|-----|-------|------|
| 0.1 | 0.5 | 0.5 | 0.015 | 0.02 |

MECHANICAL PROPERTIES

| Heat Treatment | Rp0,2 (MPa) | Rm (MPa) | A5 (%) | Impact Energy (J) ISO-V | Hardness |
|----------------|-------------|----------|--------|-------------------------|----------|
| | | | | 0°C | |
| As Welded | 410 | 530 | 26 | 60 | HRc |

REDRYING Not required

GAS ACC. EN ISO 14175



CEWELD S1

S1 2,4MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| K-415 | 25 | 8720663404251 |

S1 3,2MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| K-415 | 25 | 8720663404268 |