



# CEWELD S1

<b>TYPE</b>	Solid wire for welding non-alloyed steel	
<b>APPLICATIONS</b>	Shipbuilding, pressure vessels, steel structures.	
<b>PROPRIÉTÉS</b>	Coppered solid wire for SAW welding in combination with our FL 180 flux	
<b>CLASSIFICATION</b>	AWS	A 5.23: EL12
	EN ISO	14171-A: S1
	F-nr	6
	FM	1
<b>CONVIENT POUR</b>	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	

**AGRÉMENTS** CE

**POSITIONS DE SOUDAGE**



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

C	Si	Mn	P	S
0.1	0.5	0.5	0.015	0.02

**PROPRIÉTÉS MÉCANIQUES**

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

**ETUVAGE** 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