



CEWELD S4

TYPE Solid wire for submerged arc welding

TOEPASSINGEN Pressure vessels, shipbuilding, steel structures

EIGENSCHAPPEN High Mn alloyed welding wire that can be used in combination with the fluxes FL 155 or FL 180

CLASSIFICATIE

AWS	A 5.23: EH14
EN ISO	14171-A: S4
W.Nr.	1.5086
F-nr	6
FM	1

GESCHIKT VOOR S275JR - S355JO, E335, P285NH, P310GH, S355J0Cu, Ship construction grades A - E, Fine grain steels up-to P460N

GOEDKEURINGEN CE

LASPOSITIES



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	Cr	Ni	Mo	Cu
0.12	0.08	1.9	0.04	0.05	0.01	0.14

MECHANISCHE WAARDEN

Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness
				RT	-20°C	-40°C	
As Welded	490	600	26	120	100	85	HRc

HERDROGEN Not required

GAS ACC. EN ISO 14175