



CEWELD S4

TYPE	Solid wire for submerged arc welding							
ANWENDUNGEN	Pressure vessels, shipbuilding, steel structures							
EIGENSCHAFTEN	High Mn alloyed welding wire that can be used in combination with the fluxes FL 155 or FL 180							
KLASSIFIKATION	AWS	A 5.23: EH14						
	EN ISO	14171-A: S4						
	W.Nr.	1.5086						
	F-nr	6						
	FM	1						
GEEIGNET FÜR	S275JR - S355JO, E335, P285NH, P310GH, S355J0Cu, Ship construction grades A - E, Fine grain steels up-to P460N							
ZULASSUNGEN	CE							
SCHWEISSPOSITIONEN	PAPBPC							
TYPISCHE CHEMISCHE ANALYSE DES FÜLLMETALLS (%)	C	Si	Mn	Cr	Ni	Mo	Cu	
	0.12	0.08	1.9	0.04	0.05	0.01	0.14	
MECHANISCHE GÜTEWERTE	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
RÜCKTROCKNUNG	Not required							
GAS ACC. EN ISO 14175								