



CEWELD S2Si

TYPE

ANWENDUNGEN

EIGENSCHAFTEN

KLASSIFIKATION

GEEIGNET FÜR

ZULASSUNGEN

SCHWEISSPOSITIONEN

TYPISCHE CHEMISCHE ANALYSE DES FÜLLMETALLS (%)

MECHANISCHE GÜTEWERTE

RÜCKTROCKNUNG

GAS ACC. EN ISO 14175

Solid wire for submerged arc welding up to 420 MPa yield strength structural steels

Shipbuilding, piping, root welding, bridges, repair, construction, offshore, etc.

Solid drawn and rolled SAW wire with copper coating for improved current carrying capacity. S2 wire can be used with FL 180, FL188, FL 155 and FL 851 depending on the requirements and application.

AWS

EN ISO

F-nr

FM

A 5.17: EM12K, A 5.23: EM12K

14171-A: S2Si

6

1

A, B, D, E, St 37 - St 52-3, DIN 17 100, H I, H II, 17Mn4, 16Mo5, DIN 17 155, StE 255 - StE 355, DIN 17 102, GS-38, GS-60, DIN 1681, St 35.8, St 45.8, DIN 17 175, St 37.0 - St 52.0, DIN 1626 / 1629, St 37.4 - St 52.4, DIN 1628 / 1630, StE 290.7 TM - StE 360.7 TM, DIN 17 172, X 52

CE

PA

PB

PC

C	Si	Mn	P	S
0.1	0.3	1.1	0.015	0.015

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				0°C	-20°C	
As Welded	460	600	22	60	50	HRc

Not required