



CEWELD S4

TYPE	Solid wire for submerged arc welding							
APPLICATIONS	Pressure vessels, shipbuilding, steel structures							
PROPERTIES	High Mn alloyed welding wire that can be used in combination with the fluxes FL 155 or FL 180							
CLASSIFICATION	AWS	A 5.23: EH14						
	EN ISO	14171-A: S4						
	W.Nr.	1.5086						
	F-nr	6						
	FM	1						
SUITABLE FOR	S275JR - S355JO, E335, P285NH, P310GH, S355J0Cu, Ship construction grades A - E, Fine grain steels up-to P460N							
APPROVALS	CE							
WELDING POSITIONS	 PA  PB  PC							
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	
MECHANICAL PROPERTIES	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
REDRYING	Not required							
GAS ACC. EN ISO 14175								