








# CEWELD G1

TYPE	Copper-coated unalloyed solid rod for gas welding. (OI, R45)						
APPLICATIONS	The CEWELD G1 is designed for gas welding unalloyed steels. This process is primarily used for welding plates, pipes, and other profiles where low strength is required.						
PROPERTIES	The CEWELD G1 is designed for gas welding unalloyed steels with a minimum tensile strength of 250 MPa. The resulting joints are homogeneous and soft, and the mechanical properties are excellent.						
CLASSIFICATION	AWS	A 5.2: R45					
	EN ISO	20378: O I					
	W.Nr.	1.0324					
	F-nr	6					
	FM	1					
SUITABLE FOR	<b>Re ≤ 235 MPa (55 ksi) ISO 15608: 1.1( ReH &lt; 235 MPa )</b> 1.0034, 1.0035, 1.0037, 1.0038, 1.0039, 1.0044, 1.0108, 1.0111, 1.0114, 1.0115, 1.0116, 1.0118, 1.0119, 1.0120, 1.0122, 1.0128, 1.0166, 1.0167, 1.0170, 1.0171, 1.0252, 1.0252, 1.0253, 1.0254, 1.0255, 1.0308 E 190, S185, S235JRG2, S235JR S235JRH, P235S, S235J2G3, P235TR1, P235TR2, P235GH, P235GH, P235GH, P195GH, P245GH, L245ME, GE200, C 22.3, C 21 , GE240, P215NL, P275N, S275N, S275NL, GP240GH, P275SL, <b>ASTM:</b> A36, A106 grades A/B, A139 grade A, A216 grades WCA/WCB/WCC, A234 grade WPB						
APPROVALS	CE						
WELDING POSITIONS	      						
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si			Mn		
	0.08	0.1			0.5		
MECHANICAL PROPERTIES	Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
					RT	0°C	
	As Welded	300	400	20	35	30	HRc
REDRYING	Not required						
GAS ACC. EN ISO 14175	None						