



CEWELD GALVA

TYPE Ultra low alloyed electrode for welding Armco steels

APPLICATIONS Joining steels that require either low yield strength and or welding kettle steels used in galvanising plants to prevent Zn sticking on the surface.

PROPERTIES Crack resistant weld metal conditioned by the Acid type of slag. Low spatter loss, easy slag removal. Well suited for joining and rebuilding with extreme low Carbon, Silicon and Manganese content in the weld deposit.

CLASSIFICATION	AWS	A 5.1: E 6013
	EN ISO	2560-A: E 38 RA 12
	F-nr	2
	FM	1

SUITABLE FOR	Base materials	EN	W.Nr
	Unalloyed steels	St 33 to St 42.3	1.0035 til 1.0136, 1.1013
	Thin steels	1623/1	

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn
0.03	0.15	0.2

MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V	Hardness
				0°C	
As Welded	415	530	22	55	HRc

REDRYING Not required

GAS ACC. EN ISO 14175