



CEWELD S1

TYPE Solid wire for welding non-alloyed steel

APPLICATIONS Shipbuilding, pressure vessels, steel structures.

PROPERTIES Coppered solid wire for SAW welding in combination with our FL 180 flux

CLASSIFICATION

AWS	A 5.23: EL12, A 5.17: EL12
EN ISO	14171-A: S1
F-nr	6
FM	1

SUITABLE FOR Unalloyed steels: St 33 – St 52 Ship building: A, E, AH, EH Boiler steels: H1-H111, 17Mn4, Pipe steels: St 37.0/4 – St 52.0/4 Fine-grain steels: StE 255 – StE 420

APPROVALS CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

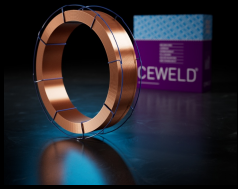
C	Si	Mn	P	S
0.1	0.5	0.5	0.015	0.02

MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V	Hardness
				0°C	
As Welded	410	530	26	60	HRc

REDRYING Not required

GAS ACC. EN ISO 14175



CEWELD S1

S1 2,4MM

Packaging	KG/unit	EanCode
K-415	25	8720663404251

S1 3,2MM

Packaging	KG/unit	EanCode
K-415	25	8720663404268