



CEWELD G4

TYPE High strength Mn / Mo- alloyed filler metal for flame welding with extreme good flowing properties without spatters during welding.(R60-G, OIV)

APPLICATIONS CEWELD® GIV is for Gas-welding of high-temperature low-alloy steels. Fields of application are. Boiler, tank, pipeline, equipment and reactor construction.Finegrain and creep resistant molybdenum containing steels.

PROPERTIES CEWELD® GIV is a high-strength manganese-molybdenum alloyed filler metal for flame welding with excellent flow properties and minimal spatter during welding. It has excellent mechanical strength due to the addition of molybdenum, making it ideal for heat-resistant applications up to 500°C. The deposit is homogeneous and suitable for heat treatment (PWHT).

CLASSIFICATION

AWS	A 5.2: R60-G
EN ISO	20378: O IV
F-nr	6
FM	1

SUITABLE FOR **Typ 0,5Mo ≤ 460 MPa, ISO 15608: 1.2, 1.3**
 1.5415, 1.0481, 1.0482
15Mo3, 16Mo3, 20MnMoNi4-5, 15NiCuMoNb5, S235JR-S355JR, S235JO-S355JO, S450JO, S235J2-S355J2, S275N-S460N, S275M-S460M, P235GH-P355GH, P355N, P285NH-P460NH, P195TR1-P265TR1, P195TR2-P265TR2, P195GH-P265GH, L245NB-L415NB, L450QB, L245MB-L450MB, GE200-GE300
 ASTM: A 29 Gr. 1013, 1016; A 106 Gr. C; A, B; A 182 Gr. F1; A 234 Gr. WP1; A 283 Gr. B, C, D; A 335 Gr. P1; A 501 Gr. B; A 533 Gr. B, C; A 510 Gr. 1013; A 512 Gr. 1021, 1026; A 513 Gr. 1021, 1026; A 516 Gr. 70; A 633 Gr. C; A 678 Gr. B; A 709 Gr. 36, 50; A 711 Gr. 1013;
 API 5 L B, X42, X52, X60, X65

APPROVALS CE

WELDING POSITIONS



C	Si	Mn	Mo
0.12	0.2	1.1	0.5

Heat Treatment	Rp0,2 (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V	Hardness
				RT	
As Welded	350	500	22	60	HRc

REDRYING Not required

GAS ACC. EN ISO 14175 None