



# CEWELD G1

|                                                      |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                         |                      |                    |                         |     |          |
|------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------|----------------------|--------------------|-------------------------|-----|----------|
| TYPE                                                 | Copper-coated unalloyed rod for gas welding.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                         |                      |                    |                         |     |          |
| APPLICATIONS                                         | Gas welding of unalloyed steels with a minimum tensile strength of 340 MPa. Mainly used for welding plates, pipes and other profiles with low strenght required.                                                                                                                                                                                                                                                                                                                                                                                                                                            |                         |                      |                    |                         |     |          |
| PROPRIÉTÉS                                           | Joints are homogenous and soft, the mechanical treatment is very good.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                         |                      |                    |                         |     |          |
| CLASSIFICATION                                       | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | A 5.2: R45              |                      |                    |                         |     |          |
|                                                      | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | 20378: O I              |                      |                    |                         |     |          |
|                                                      | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | 1.0324                  |                      |                    |                         |     |          |
|                                                      | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | 6                       |                      |                    |                         |     |          |
|                                                      | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | 1                       |                      |                    |                         |     |          |
| CONVIENT POUR                                        | <b>Re ≤ 235 MPa (55 ksi) ISO 15608: 1.1( ReH &lt; 235 MPa )</b><br>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<br>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,<br><b>ASTM:</b> A36, A106 grades A/B, A139 grade A, A216 grades WCA/WCB/WCC, A234 grade WPB                      |                         |                      |                    |                         |     |          |
| AGRÉMENTS                                            | CE                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                         |                      |                    |                         |     |          |
| POSITIONS DE SOUDAGE                                 |        |                         |                      |                    |                         |     |          |
| ANALYSE CHIMIQUE<br>TYPIQUE DU MÉTAL<br>D'APPORT (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | Si                      |                      |                    | Mn                      |     |          |
|                                                      | 0.08                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | 0.1                     |                      |                    | 0.5                     |     |          |
| PROPRIÉTÉS MÉCANIQUES                                | 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      |
| ETUVAGE                                              | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                         |                      |                    |                         |     |          |
| GAS ACC. EN ISO 14175                                | None                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                         |                      |                    |                         |     |          |