



CEWELD S4 MoSi

TYPE	Solid wire for submerged arc welding with high Manganese content and 0,5% Mo.							
APPLICATIONS	Fine grain steels for yield strength applications exceeding 500 MPa. Often used for pipe welding (X70-X80) when Mn. and Si. content is low..							
PROPRIÉTÉS	High Manganese and Silicon content for improved de-oxidation and strength, excellent wetting for increased welding speed with corresponding flux. Suitable fluxes are depending on the weld metal requirements, in most cases CEWELD® FL 155 gives excellent results.							
CLASSIFICATION	AWS	A 5.23: EA3K						
	EN ISO	14341-A: G4Mo						
	F-nr	6						
	FM	3						
CONVIENT POUR	Pipe steels acc. to ISO 3183, EN 10208 and API-5: L360N/X52 to L555Q/X80							
AGRÉMENTS								
POSITIONS DE SOUDAGE	  							
ANALYSE CHIMIQUE TYPIQUE DU MÉTAL D'APPORT (%)	C	Si	Mn	P	S	Mo		
	0.1	0.7	1.8	0.015	0.015	0.5		
PROPRIÉTÉS MÉCANIQUES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Impact Energy (J) ISO-V			Hardness
	As Welded				-20°C	-40°C	0°C	
	580°C±15°C 2h	550	680	20	60	50	HRc	
					80	60	50	HRc
ETUVAGE	Not required							
GAS ACC. EN ISO 14175								



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Packaging	KG/unit	EanCode
K-415	25	8720663404701