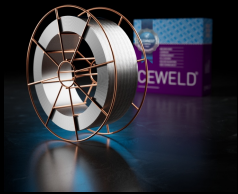




# CEWELD Ultra Clean II

|                                             |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                                   |                      |                    |                                  |          |
|---------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------|----------------------|--------------------|----------------------------------|----------|
| TYPE                                        | Solid wire, uncoppered, for welding unalloyed and low-alloy steels up to 420 MPa yield strength. (ER70S-6, G3Si1)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                   |                      |                    |                                  |          |
| APPLICATIONS                                | CEWELD® Ultra Clean II can be used universally in tank, boiler and general steel construction as well as in shipbuilding and pipeline construction...                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                                   |                      |                    |                                  |          |
| PROPERTIES                                  | CEWELD® Ultra Clean II has one of the lowest fume emissions of any welding wire on the market. As a virtually copper-free wire with a maximum of 0.03% copper, it is very environmentally friendly to manufacture and use. But what really sets it apart is the protection of the welder's health, as exposure to copper during welding is virtually eliminated. Arc stability is improved by a special coating which also reduces friction in the torch by approximately 50% compared to copper coated welding wire. The weld is virtually free of silicates, minimising the need for rework. CEWELD® Ultra Clean II offers excellent notch impact values down to -40°C due to the pure weld metal analysis.                                                                                                                                                                                                                                                                                                                                             |                                                   |                      |                    |                                  |          |
| CLASSIFICATION                              | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | A 5.18: ER 70S-6                                  |                      |                    |                                  |          |
|                                             | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | 14341-A: G 42 4 M21 3Si1, 14341-A: G 42 3 C1 3Si1 |                      |                    |                                  |          |
|                                             | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | 6                                                 |                      |                    |                                  |          |
|                                             | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | 1                                                 |                      |                    |                                  |          |
| SUITABLE FOR                                | <b>Rp&lt; 420 MPa (60ksi) ISO 15608: 1.1( ReH &lt; 275 MPa ), 1.2 (275 &lt; ReH &lt; 360 MPa), 1.3 (ReH &gt; 360 MPa &lt; 420 MPa)</b><br>1.0035, 1.0038, 1.0039, 1.0044, 1.0112, 1.0116, 1.0130, 1.0145, 1.0253, 1.0254, 1.0255, 1.0258, 1.0259, 1.0319, 1.0345, 1.0345, 1.0345, 1.0348, 1.0352, 1.0418, 1.0420, 1.0425, 1.0425, 1.0425, 1.0451, 1.0452, 1.0453, 1.0457, 1.0459, 1.0460, 1.0461, 1.0486, 1.0490, 1.0491, 1.0619, 1.1100, 1.0409, 1.0421, 1.0426, 1.0429, 1.0430, 1.0436, 1.0473, 1.0481, 1.0482, 1.0484, 1.0505, 1.0545, 1.0546, 1.0562, 1.0566, 1.0570, 1.0578, 1.0581, 1.0582, 1.8902, 1.8912, 1.8932<br>10Ni14, 12Ni14, 13MnNi6-3, 15NiMn6,<br>S235JR-S355JR, S235JO-S355JO, P195TR1-P265TR1, P195GH-P265GH, L245NB-L360NB, L245MB-L360MB, L415NB, L415MB, WStE 380, WStE 420, S420NL<br>A, B, D, E, A 32-E 36<br><b>ASTM</b> A 105, A 106, Gr. A, B; A 283 Gr. A, C; A 285 Gr. A, B, C; A 501, Gr. B; A 573, Gr. 58, 65, 70; A 633, Gr. A, C; A 711 Gr. 1013;<br><b>API</b> 5 L Gr. B, X42, X52, X60<br>Domex 315-420MC, MC Plus, ML |                                                   |                      |                    |                                  |          |
| APPROVALS                                   | CE, TÜV: (20379), DB: 42.206.06                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                                   |                      |                    |                                  |          |
| WELDING POSITIONS                           | <div></div>                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                                   |                      |                    |                                  |          |
| TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | Si                                                | Mn                   | P                  | S                                | Cu       |
|                                             | 0.07                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | 0.8                                               | 1.45                 | 0.015              | 0.015                            | 0.015    |
| MECHANICAL PROPERTIES                       | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | R <sub>P0.2</sub> (MPa)                           | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V<br>-40°C | Hardness |
|                                             | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | 450                                               | 550                  | 31                 | 95                               | HRc      |
| REDRYING                                    | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                   |                      |                    |                                  |          |
| GAS ACC. EN ISO 14175                       | M20, M21                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                   |                      |                    |                                  |          |



# CEWELD Ultra Clean II

## ULTRA CLEAN II 0.8MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| D-200     | 5       | 8720682051863 |
| BS-300    | 16      | 8720682051856 |
| Drum      | 250     | 8720682051870 |

## ULTRA CLEAN II 1.0MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| D-200     | 5       | 8720682051894 |
| BS-300    | 16      | 8720682051887 |
| Drum      | 250     | 8720682051900 |

## ULTRA CLEAN II 1.2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| D-200     | 5       | 8720682051924 |
| BS-300    | 16      | 8720682051917 |
| Drum      | 250     | 8720682051931 |

## ULTRA CLEAN II 1,6MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 16      | 8720663424792 |