



CEWELD S4

TYPE

APPLICATIONS

PROPRIÉTÉS

CLASSIFICATION

CONVIENT POUR

AGRÉMENTS

POSITIONS DE SOUDAGE

ANALYSE CHIMIQUE
TYPIQUE DU MÉTAL
D'APPORT (%)

PROPRIÉTÉS MÉCANIQUES

ETUVAGE

GAS ACC. EN ISO 14175

Solid wire for submerged arc welding

Pressure vessels, shipbuilding, steel structures

High Mn alloyed welding wire that can be used in combination with the fluxes FL 155 or FL 180

AWS

EN ISO

W.Nr.

F-nr

FM

A 5.23: EH14

14171-A: S4

1.5086

6

1

S275JR - S355JO, E335, P285NH, P310GH, S355J0Cu, Ship construction grades A - E, Fine grain steels up-to P460N

CE

PA

PB

PC

C	Si	Mn	Cr	Ni	Mo	Cu
0.12	0.08	1.9	0.04	0.05	0.01	0.14

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness
				RT	-20°C	-40°C	
As Welded	490	600	26	120	100	85	HRc

Not required