



CEWELD S4

TYPE	Solid wire for submerged arc welding							
APPLICATIONS	Pressure vessels, shipbuilding, steel structures							
PROPRIÉTÉS	High Mn alloyed welding wire that can be used in combination with the fluxes FL 155 or FL 180							
CLASSIFICATION	AWS	A 5.23: EH14						
	EN ISO	14171-A: S4						
	W.Nr.	1.5086						
	F-nr	6						
	FM	1						
CONVIENT POUR	S275JR - S355JO, E335, P285NH, P310GH, S355J0Cu, Ship construction grades A - E, Fine grain steels up-to P460N							
AGRÉMENTS	CE							
POSITIONS DE SOUDAGE	PAPBPC							
ANALYSE CHIMIQUE TYPIQUE DU MÉTAL D'APPORT (%)	C	Si	Mn	Cr	Ni	Mo	Cu	
	0.12	0.08	1.9	0.04	0.05	0.01	0.14	
PROPRIÉTÉS MÉCANIQUES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness
	As Welded	490	600	26	RT	-20°C	-40°C	HRc
ETUVAGE	Not required							
GAS ACC. EN ISO 14175								