CEWELD G2

certilas® THE FILLER METAL SPECIALIST

TYPE	Copper-coated unalloyed rod for gas welding
TOEPASSINGEN	Gas welding of unalloyed steels with a minimum tensile strength of 400 MPa
EIGENSCHAPPEN	Joints are homogenous and soft, the mechanical treatment is very good

CLASSIFICATIE

AWS	A 5.2: R60
EN ISO	20378: O II
W.Nr.	1.0494
F-nr	6
FM	1

GESCHIKT VOOR

Re ≤ 300 MPa (55 ksi) ISO 15608: 1.1(ReH < 275 MPa) 1.2 (275 < ReH < 300 MPa)
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, 1.0427, 1.0432, 1.0446, 1.0451, 1.0452, 1.0453, 1.0457, 1.0459, 1.0460, 1.0460, 1.0461, 1.0486, 1.0490, 1.0491, 1.0505, 1.0545, 1.0546, 1.0562, 1.0566, 1.0570, 1.0578, 1.0581, 1.0582, 1.1138, 1.5419, 1.8948
C 22.8 S1, S185, S235JRG2, S235JR S235JRH, S275JR, P235S, S235J2G3, P265S, S275J2, P235TR1, P235TR2, P265TR1, P265TR2, P235GH, P235GH, P235GH, P195GH, P245GH, L245ME, GE200, P265GH, P265GH, P265GH, C 22.3, C 21 , GE240, P215NL, P 250, P255QL, P265NL, L245NE, C 22.8, P250GH, P275N, S275N, S275NL, GP240GH, P275SL, 21 Mn 6, StE 320.7, St 52.0, P280GH, (X42ME) L290ME, P305GH, P355GH, P295GH, L290NE, S355N, S355NL, P355N, P355NL1, S355J2G3, G21Mn5, G20Mo5, X52QE,
ASTM: A 105, A 27 u. A36 Gr. all; A214; A 242 Gr.1-5; A266 Gr. 1, 2, 4; A283 Gr. A, B, C, D; A285 Gr. A, B, C; A299 Gr. A, B; A328; A366; A515 Gr. 60, 65, 70; A516 Gr. 55; A570 Gr. 30, 33, 36, 40, 45; A 572 Gr. 42, 50; A606 Gr. Alle; A607 Gr. 45; A656 Gr. 50, 60; A668 Gr. A, B; A907 Gr. 30, 33, 36, 40; A841; A851 Gr. 1, 2; A935 Gr.45; A936 Gr. 50;
API 5 L Gr. B, X42-X52

GOEDKEURINGEN: CE

LASPOSITIES

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn
0.1	0.15	1.1

MECHANISCHE WAARDEN

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V	Hardness
				RT	
As Welded	320	450	21	50	HRc

HERDROGEN: Not required

GAS ACC. EN ISO 14175: None