CEWELD S4 MoSi

certilas® THE FILLER METAL SPECIALIST

TYPE

Solid wire for submerged arc welding with high Manganese content and 0,5% Mo.

ANWENDUNGEN

Fine grain steels for yield strength aplications exceeding 500 MPa. Often used for pipe welding (X70-X80) when Mn. and Si. content is low..

EIGENSCHAFTEN

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.

KLASSIFIKATION

AWS	A 5.23: EA3K
EN ISO	14341-A: G4Mo
F-nr	6
FM	3

GEEIGNET FÜR

Pipe steels acc. to ISO 3183, EN 10208 and API-5: L360N/X52 to L555Q/X80

ZULASSUNGEN

SCHWEISSPOSITIONEN

TYPISCHE CHEMISCHE ANALYSE DES FÜLLMETALLS (%)

C	Si	Mn	P	S	Mo
0.1	0.7	1.8	0.015	0.015	0.5

MECHANISCHE GÜTEWERTE

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V				Hardness
				-20°C	-40°C	0°C	-30°C	
As Welded				60	50	HRc		
580°C±15°C 2h	550	680	20	80	60	50	HRc	

RÜCKTROCKNUNG

Not required

GAS ACC. EN ISO 14175

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S4 MOSI 4,0MM

Packaging	KG/unit	EanCode
K-415	25	8720663404701