



CEWELD S2Si

TYPE	Solid wire for submerged arc welding up to 420 MPa yield strength structural steels						
APPLICATIONS	Shipbuilding, piping, root welding, bridges, repair, construction, offshore, etc.						
PROPRIÉTÉS	Solid drawn and rolled SAW wire with copper coating for improved current carrying capacity. S2 wire can be used with FL 180, FL188, FL 155 and FL 851 depending on the requirements and application.						
CLASSIFICATION	AWS	A 5.17: EM12K, A 5.23: EM12K					
	EN ISO	14171-A: S2Si					
	F-nr	6					
	FM	1					
CONVIENT POUR	A, B, D, E, St 37 - St 52-3, DIN 17 100, H I, H II, 17Mn4, 16Mo5, DIN 17 155, StE 255 - StE 355, DIN 17 102, GS-38, GS-60, DIN 1681, St 35.8, St 45.8, DIN 17 175, St 37.0 - St 52.0, DIN 1626 / 1629, St 37.4 - St 52.4, DIN 1628 / 1630, StE 290.7 TM - StE 360.7 TM, DIN 17 172, X 52						
AGRÉMENTS	CE						
POSITIONS DE SOUDAGE	 PA  PB  PC						
ANALYSE CHIMIQUE TYPIQUE DU MÉTAL D'APPORT (%)	C	Si	Mn	P	S		
	0.1	0.3	1.1	0.015	0.015		
PROPRIÉTÉS MÉCANIQUES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
	As Welded	460	600	22	0°C	-20°C	
					60	50	HRc
ETUVAGE	Not required						
GAS ACC. EN ISO 14175							