CEWELD®

S4 MoSi

CATEGORY	SAW Arc Submerged
TYPE	Solid wire for submerged arc welding with high Manganese content and 0,5% Mo.
APPLICATIONS	Fine grain steels for yield strength aplications exceeding 500 MPa. Often used for pipe welding (X70-X80) when Mn. and Si. content is low..
PROPERTIES	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.
CLASSIFICATION	AWS A 5.23: EA3K EN ISO 14341-A: G4Mo
SUITABLE FOR	Pipe steels acc. to ISO 3183, EN 10208 and API-5: L360N/X52 to L555Q/X80
APPROVALS	CE approved
WELDING POSITIONS:	

FILLER METAL ANALYSIS WT. %

C	Mn	Si	S	P	Cr	Ni	Mo	Cu
0.05-0.15	1.6-2.1	0.5-0.8	<0.025	<0.025			0.4-0.6	<0.35

TYPICAL MECHANICAL PROPERTIES

Combination Flux type	$R_{P0,2}$ MPa	Rm Mpa	A5 (%)	Impact Energy (J) ISO-V -20°C	-40°C	-60°C	Hardness HRc / HV
FL 155	570	650	18	60	47		

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing	
D (mm)	Voltage (V)	Current (A)	spooling type	kg / spool / drum
2,0	28-30	250-400	K-415 / Drum	25 / 300
2.4	28-32	300-600	K-415 / Drum	25 / 300
3.2	28-34	350-700	K-415 / Drum	25 / 300
4.0	28-36	450-800	K-415 / Drum	25 / 300

REDRYING TEMPERATURE	not required