
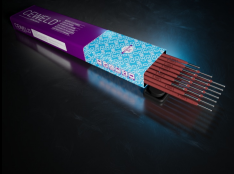


# CEWELD E 1000 S

TYPE	Universal rutile electrode for all positions. (Type E 6013, E42 0)																		
APPLICATIONS	CEWELD® E 1000 S is a medium thick coated electrode suitable for general construction and offers a very smooth seam surface. Trucks, trailers, wagons, shipbuilding, yacht building, root runs in pipe welding, repair welding etc.																		
PROPERTIES	CEWELD® E 1000 S is suitable for all positions; 2,5 mm can even be used in vertical down position. Medium fast freezing weld metal makes this electrode excellently suitable for root runs in vertical up position in pipe welding. The slag is self detaching and the special red coating was developed to offer high resistance against moisture pick up.																		
CLASSIFICATION	AWS                                    A 5.1: E 6013 EN ISO                                2560-A: E 42 0 RR 12 F-nr                                    1 FM                                      1																		
SUITABLE FOR	<b>Rp &lt; 420 MPa (60ksi) ISO 15608: 1.1 ReH &lt; 275 MPa, 1.2 275 &lt; ReH &lt; 360 MPa , (1.3 ReH &gt; 360 MPa &lt; 420 MPa) AV max 0°C</b> 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, 1.0451, 1.0452, 1.0453, 1.0457, 1.0459, 1.0460, 1.0460, 1.0461, 1.0486, 1.0490, 1.0491, 1.0619, 1.1100, 1.0409, 1.0421, 1.0426, 1.0429, 1.0430, 1.0436, 1.0473, 1.0481, 1.0482, 1.0484, 1.0505, 1.0545, 1.0546, 1.0562, 1.0566, 1.0570, 1.0578, 1.0581, 1.0582, 1.8902, 1.8912, 1.8932 S235JR-S355JR, S235JO-S355JO, P195TR1-P265TR1, P195GH-P265GH, L245NB-L360NB, L245MB-L360MB, L415NB, L415MB, WStE 380, WStE 420, S420NL A, B, D ASTM A 106, Gr. A, B; A 283 Gr. A, C; A 285 Gr. A, B, C; A 501, Gr. B; A 573, Gr. 58, 65, 70; A 633, Gr. A, C; A 711 Gr. 1013; API 5 L Gr. B, X42, X52, X56, X60, X65 (Root X 80)																		
APPROVALS	CE																		
WELDING POSITIONS																			
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td>C</td> <td>Si</td> <td>Mn</td> <td>Cr</td> <td>Ni</td> <td>Mo</td> <td>V</td> <td>Cu</td> <td>Nb</td> </tr> <tr> <td>0.09</td> <td>0.45</td> <td>0.5</td> <td>0.05</td> <td>0.06</td> <td>0.02</td> <td>0.02</td> <td>0.1</td> <td>0.01</td> </tr> </table>	C	Si	Mn	Cr	Ni	Mo	V	Cu	Nb	0.09	0.45	0.5	0.05	0.06	0.02	0.02	0.1	0.01
C	Si	Mn	Cr	Ni	Mo	V	Cu	Nb											
0.09	0.45	0.5	0.05	0.06	0.02	0.02	0.1	0.01											
ALL WELD MECHANICAL PROPERTIES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td rowspan="2">Heat Treatment</td> <td>R<sub>p0,2</sub></td> <td>R<sub>m</sub></td> <td>A<sub>5</sub></td> <td rowspan="2">Impact Energy (J) ISO-V</td> </tr> <tr> <td>MPa</td> <td>MPa</td> <td>(%)</td> </tr> <tr> <td>As Welded /</td> <td>450</td> <td>560</td> <td>24</td> <td>60</td> </tr> </table>	Heat Treatment	R <sub>p0,2</sub>	R <sub>m</sub>	A <sub>5</sub>	Impact Energy (J) ISO-V	MPa	MPa	(%)	As Welded /	450	560	24	60					
Heat Treatment	R <sub>p0,2</sub>		R <sub>m</sub>	A <sub>5</sub>	Impact Energy (J) ISO-V														
	MPa	MPa	(%)																
As Welded /	450	560	24	60															
REDRYING TEMPERATURE	140°C / 1 hr																		
GAS ACCORDING EN 14175	None																		



# CEWELD E 1000 S

E 1000 S 2,5 X 350MM

Type	KG/unit	EANCode
Vacuum	2,0	8720663400215

E 1000 S 3,2 X 350MM

Type	KG/unit	EANCode
Vacuum	2,2	8720663400222

E 1000 S 4,0 X 350MM

Type	KG/unit	EANCode
Vacuum	2,0	8720663400239