



CEWELD S4 MoSi

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

APPLICATIONS Fine grain steels for yield strength applications 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
F-nr	6
FM	3

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

APPROVALS No Approvals Found

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

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

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V			
				-20°C	-40°C	0°C	-30°C
As Welded / 580°C±15°C /2h	550	680	20	60	50	80	60

REDRYING TEMPERATURE Not required

GAS ACCORDING EN 14175



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S4 MOSI 4,0MM

Type	KG/unit	EANCode
K-415	25	8720663404701