


CEWELD G4

TYPE	High strength Mn / Mo- alloyed filler metal for flame and Tig welding with extreme good flowing properties without spatters during welding.				
APPLICATIONS	Finegrain and creep resistant molybdenum containing steels. Suitable for working temperatures up to 500°Celsius. It's suited in trade and industry for welding plates, pipes, boilers and other profiles.				
PROPERTIES	High strength Manganese-Molybdenum- alloyed filler metal for flame welding with extreme good flowing properties without spatters during welding. Excelent mechanical strenght due to the addition of Molybdenium.The deposit is homogenous and suitable for heat treatment (PWHT).				
CLASSIFICATION	AWS EN ISO F-nr FM	A 5.2: R60-G 20378: O IV 6 1			
SUITABLE FOR	St37, St42, St35.8, St45.8, 15Mo3, HI, HIII, HII, 17Mn4, 1.0038, 1.0570, 1.0305, 1.0405, 1.5415, 1.0345, 1.0435, 1.0481, 15Mo3, 16Mo3				
APPROVALS	CE				
WELDING POSITIONS					
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C 0.12	Si 0.2	Mn 1.1	Mo 0.5	
ALL WELD MECHANICAL PROPERTIES	Heat Treatment As Welded /	R _{P0,2} MPa 350	R _m MPa 500	A5 (%) 22	Impact Energy (J) ISO-V RT 60
REDRYING TEMPERATURE	Not required				
GAS ACCORDING EN 14175	None				