



# CEWELD G1

<b>TYPE</b>	Copper-coated unalloyed rod for gas welding.															
<b>APPLICATIONS</b>	Gas welding of unalloyed steels with a minimum tensile strength of 340 MPa. Mainly used for welding plates, pipes and other profiles with low strenght required.															
<b>PROPERTIES</b>	Joints are homogenous and soft, the mechanical treatment is very good.															
<b>CLASSIFICATION</b>	AWS	A 5.2: R45														
	EN ISO	20378: 01														
	F-nr	6														
	FM	1														
	W.Nr.	1.0324														
<b>SUITABLE FOR</b>	1.0035, 1.0561, 1.0308, 1.0305 S185, S235JR, St33, St52, St35, St35.8, ASTM: A36, A106 grades A/B, A139 grade A, A216 grades WCA/WCB/WCC, A234 grade WPB															
<b>APPROVALS</b>	CE															
<b>WELDING POSITIONS</b>																
<b>TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)</b>	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 33%; text-align: center;">C</td> <td style="width: 33%; text-align: center;">Si</td> <td style="width: 33%; text-align: center;">Mn</td> </tr> <tr> <td style="text-align: center;">0.08</td> <td style="text-align: center;">0.1</td> <td style="text-align: center;">0.5</td> </tr> </table>		C	Si	Mn	0.08	0.1	0.5								
C	Si	Mn														
0.08	0.1	0.5														
<b>ALL WELD MECHANICAL PROPERTIES</b>	<table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th style="width: 15%;">Heat Treatment</th> <th style="width: 10%;">R<sub>P0,2</sub> MPa</th> <th style="width: 10%;">R<sub>m</sub> MPa</th> <th style="width: 10%;">A<sub>5</sub> (%)</th> <th style="width: 20%;">Impact Energy (J) ISO-V</th> <th style="width: 15%;">RT</th> <th style="width: 10%;">0°C</th> </tr> </thead> <tbody> <tr> <td style="text-align: center;">As Welded /</td> <td style="text-align: center;">300</td> <td style="text-align: center;">400</td> <td style="text-align: center;">20</td> <td style="text-align: center;">35</td> <td style="text-align: center;">30</td> <td></td> </tr> </tbody> </table>		Heat Treatment	R <sub>P0,2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)	Impact Energy (J) ISO-V	RT	0°C	As Welded /	300	400	20	35	30	
Heat Treatment	R <sub>P0,2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)	Impact Energy (J) ISO-V	RT	0°C										
As Welded /	300	400	20	35	30											
<b>REDRYING TEMPERATURE</b>	Not required															
<b>GAS ACCORDING EN 14175</b>	None															