



CEWELD S2

TYPE	Solid wire for submerged arc welding up to 420 MPa yield strength structural steels.				
APPLICATIONS	Shipbuilding, piping, root welding, bridges, repair, construction, offshore, etc...				
PROPERTIES	Solid drawn and rolled SAW wire with copper coating for improved current carrying capacity. S2 wire can be used with FL 180, FL188, FL 155 and FL 851 depending on the requirements and application. Approvals in combination with FL 188				
CLASSIFICATION	AWS	A 5.17: EM12K			
	AWS	A 5.23: EM12K			
	EN ISO	14171-A: S2			
	F-nr	6			
	FM	1			
	W.Nr.	1.0494			
SUITABLE FOR	A, B, D, E, St 37 - St 52-3, DIN 17 100, H I, H II, 17Mn4, 16Mo5, DIN 17 155, StE 255 - StE 355, DIN 17 102, GS-38, GS-60, DIN 1681, St 35.8, St 45.8, DIN 17 175, St 37.0 - St 52.0, DIN 1626 / 1629, St 37.4 - St 52.4, DIN 1628 / 1630, StE 290.7 TM - StE 360.7 TM, DIN 17 172, X 52				
APPROVALS	TÜV (12523) CE Lloyds DNV				
WELDING POSITIONS					
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	P	S
	0.1	0.12	1.1	0.015	0.015
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R _{p0,2} MPa	R _m MPa	A5 (%)	Impact Energy (J) ISO-V -30°C
	As Welded /	445	560	24	60
REDRYING TEMPERATURE	Not required				
GAS ACCORDING EN 14175					



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S2 1,6MM	Type	KG/unit	EANCode
	K-415	27	8720663404350

S2 2,0MM	Type	KG/unit	EANCode
	Drum	320	8720663404374
	Drum	450	8720663404381
	K-415	27	8720663404367

S2 2,4MM	Type	KG/unit	EANCode
	K-415	27	8720663404404
	Drum	300	8720663404411

S2 3,2MM	Type	KG/unit	EANCode
	K-415	27	8720663404428
	Drum	300	8720663404435

S2 4,0MM	Type	KG/unit	EANCode
	K-415	27	8720663404459
	Drum	300	8720663404473