



CEWELD S2 Ni1

TYPE	Solid wire for submerged arc welding
APPLICATIONS	Offshore, Shipbuilding, pressure vessels, crane , pipe work
PROPERTIES	Submerged arc welding wire for welding fine grain steels for low temperature requirements down to -60°C in apparatus, construction and offshore applications.

CLASSIFICATION	AWS	A 5.23: E Ni1
	EN ISO	14171-A: S2Ni1
	W.Nr.	1.6225
	F-nr	6
	FM	1

SUITABLE FOR

Materials	DIN	EN	ASTM
shipbuilding	A, B, D, E, AH 32 - EH 36	same	Typical
Unalloyed steels	St 33, St 37-2 - St 52-3	S185 - S355-S460	A 258 / A 516
boiler steels	H I, H III, 17Mn4, 19Mn5	P235GH, P355GH	A 662 / A 387
pipe steels	St 35.8, St 45.8	P235T1/T2, P460NL2	A 738 / A 612
-	StE 210.7 TM, StE 480.7 TM	L210 - L480MB	A 299
Fine grain steels	StE 255 to StE 460	S255 - S500 (NL1,2)	-
API-standard	X 42, X65, X 70	X 42, X65, X 70	-

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	Ni	P
0.08	0.2	1	0.9	0.0015

MECHANICAL PROPERTIES

REDRYING	Not required
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GAS ACC. EN ISO 14175