CEWELD Ultra Clean II

certilas® THE FILLER METAL SPECIALIST

TYPE

Solid wire, uncoppered, for welding unalloyed and low-alloy steels up to 420 MPa yield strength. (ER70S-6, G3Si1)

APPLICATIONS

CEWELD® Ultra Clean II can be used universally in tank, boiler and general steel construction as well as in shipbuilding and pipeline construction...

PROPERTIES

CEWELD® Ultra Clean II has one of the lowest fume emissions of any welding wire on the market. As a virtually copper-free wire with a maximum of 0.03% copper, it is very environmentally friendly to manufacture and use. But what really sets it apart is the protection of the welder's health, as exposure to copper during welding is virtually eliminated. Arc stability is improved by a special coating which also reduces friction in the torch by approximately 50% compared to copper coated welding wire. The weld is virtually free of silicates, minimising the need for rework. CEWELD® Ultra Clean II offers excellent notch impact values down to -40°C due to the pure weld metal analysis.

CLASSIFICATION

AWS	A 5.18: ER 70S-6
EN ISO	14341-A: G 42 4 M21 3Si1, 14341-A: G 42 3 C1 3Si1
F-nr	6
FM	1

SUITABLE FOR

Rp< 420 MPa (60ksi) ISO 15608: 1.1(ReH < 275 MPa), 1.2 (275 < ReH < 360 MPa), 1.3 (ReH > 360 MPa < 420 MPa)
1.0035, 1.0038, 1.0039, 1.0044, 1.0112, 1.0116, 1.0130, 1.0145, 1.0253, 1.0254, 1.0255, 1.0258, 1.0259, 1.0319, 1.0345, 1.0345, 1.0345, 1.0348, 1.0352, 1.0418, 1.0420, 1.0425, 1.0425, 1.0425,1.0451, 1.0452, 1.0453, 1.0457, 1.0459, 1.0460, 1.0461, 1.0486, 1.0490, 1.0491, 1.0619, 1.1100, 1.0409, 1.0421, 1.0426, 1.0429, 1.0430, 1.0436, 1.0473, 1.0481, 1.0482, 1.0484, 1.0505, 1.0545, 1.0546, 1.0562, 1.0566, 1.0570, 1.0578, 1.0581, 1.0582, 1.8902, 1.8912, 1.8932
10Ni14, 12Ni14, 13MnNi6-3, 15NiMn6,
S235JR-S355JR, S235JO-S355JO, P195TR1-P265TR1, P195GH-P265GH, L245NB-L360NB, L245MB-L360MB, L415NB, L415MB, WStE 380, WStE 420, S420NL
A, B, D, E, A 32-E 36
ASTM A 105, A 106, Gr. A, B; A 283 Gr. A, C; A 285 Gr. A, B, C; A 501, Gr. B; A 573, Gr. 58, 65, 70; A 633, Gr. A, C; A 711 Gr. 1013;
API 5 L Gr. B, X42, X52, X60
Domex 315-420MC,MC Plus, ML

APPROVALS

CE, TÜV: (20379), DB: 42.206.06

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Cu
0.07	0.85	1.45	0.015	0.015	0.015

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V	Hardness
				-40°C	
As Welded	450	550	31	95	HRc

REDRYING

Not required

GAS ACC. EN ISO 14175

M20, M21

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ULTRA CLEAN II 0.8MM

Packaging	KG/unit	EanCode
D-200	5	8720682051863
BS-300	16	8720682051856
Drum	250	8720682051870

ULTRA CLEAN II 1.0MM

Packaging	KG/unit	EanCode
D-200	5	8720682051894
BS-300	16	8720682051887
Drum	250	8720682051900

ULTRA CLEAN II 1.2MM

Packaging	KG/unit	EanCode
D-200	5	8720682051924
BS-300	16	8720682051917
Drum	250	8720682051931

ULTRA CLEAN II 1,6MM

Packaging	KG/unit	EanCode
BS-300	16	8720663424792