# CEWELD S3Si

certilas® THE FILLER METAL SPECIALIST

TYPE

Solid drawn copper coated wire for the SAW process

ANWENDUNGEN

Pipe work; offshore, pressure vessels, bridge, crane building, apparatus, and steam turbine construction.

EIGENSCHAFTEN

Excellent mechanical strength and welding properties due to a increased manganese and silicon content. S3Si is best to be used with FL 155 high basic agglomerated flux to obtain neutral action on metallurgical chemistry and excellent subzero impact properties down to -60°C.

KLASSIFIKATION

| | |
|---|---|
| AWS | A 5.17: EH12K, A 5.23: EH12K |
| EN ISO | 14171-A: S3Si |
| W.Nr. | 1.0496 |
| F-nr | 6 |
| FM | 1 |

GEEIGNET FÜR

| **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 | 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 445.7 TM | L210 - L445MB | A 299 |
| Fine grain steels | StE 255 to StE 460 | S235 - S460QL1 | - |
| API-standard | X 42, X65, X 70 | X 42, X65, X 70 | - |

ZULASSUNGEN

DNV, Lloyds

SCHWEISSPOSITIONEN

TYPISCHE CHEMISCHE ANALYSE DES FÜLLMETALLS (%)

| C | Si | Mn | P | S |
|---|---|---|---|---|
| 0.1 | 0.35 | 1.75 | 0.015 | 0.015 |

MECHANISCHE GÜTEWERTE

| Heat Treatment | $R_{P0,2}$ (MPa) | Rm (MPa) | A5 (%) | Impact Energy (J) ISO-V | | | Hardness |
|---|---|---|---|---|---|---|---|
| | | | | RT | -40°C | -60°C | |
| As Welded | 485 | 580 | 27 | 120 | 100 | 60 | HRc |

RÜCKTROCKNUNG

Not required

GAS ACC. EN ISO 14175

# CEWELD S3Si



S3SI 2,4MM

| Packaging | KG/unit | EanCode |
|---|---|---|
| Drum | 300 | 8720663404510 |
| K-415 | 25 | 8720663404503 |

S3SI 3,2MM

| Packaging | KG/unit | EanCode |
|---|---|---|
| K-415 | 27 | 8720663404527 |

S3SI 4,0MM

| Packaging | KG/unit | EanCode |
|---|---|---|
| K-415 | 25 | 8720663404534 |