



CEWELD S3

TYPE

APPLICATIONS

PROPRIÉTÉS

CLASSIFICATION

CONVIENT POUR

AGRÉMENTS

POSITIONS DE SOUDAGE

ANALYSE CHIMIQUE
TYPIQUE DU MÉTAL
D'APPORT (%)

PROPRIÉTÉS MÉCANIQUES

ETUVAGE

GAS ACC. EN ISO 14175

Solid drawn copper coated wire for the SAW process

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

S3 is a Solid wire for CMn and mild steels with yield strength up to ~460 MPa Typical with FL 155 Flux.

AWS

EN ISO

F-nr

FM

A 5.17: EH10K, A 5.23: EH10K

14171-A: S3

6

1

S275N-S420N, S275M-S420M, Fine grain P355N/S355NL-P460M/S460NL Shipbuilding grades A-E, AH40-EH40, Boiler steels P235GH-P355GH.

CE

PA

PB

PC

C	Si	Mn	P	S
0.1	0.1	1.5	0.015	0.015

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				-40°C	-60°C	
As Welded	500	620	20	80	60	HRc

Not required