


# CEWELD S3

TYPE	Solid drawn copper coated wire for the SAW process						
APPLICATIONS	Pipe work; offshore, pressure vessels, bridge, crane building, apparatus, and steam turbine construction.						
PROPERTIES	S3 is a Solid wire for CMn and mild steels with yield strength up to ~460 MPa Typical with FL 155 Flux.						
CLASSIFICATION	AWS	A 5.17: EH10K, A 5.23: EH10K					
	EN ISO	14171-A: S3					
	F-nr	6					
	FM	1					
SUITABLE FOR	S275N-S420N, S275M-S420M, Fine grain P355N/S355NL-P460M/S460NL Shipbuilding grades A-E, AH40-EH40, Boiler steels P235GH-P355GH.						
APPROVALS	CE						
WELDING POSITIONS							
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	P	S		
	0.1	0.1	1.5	0.015	0.015		
MECHANICAL PROPERTIES	Heat Treatment	R <sub>p0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
					-40°C	-60°C	
	As Welded	500	620	20	80	60	HRC
REDRYING	Not required						
GAS ACC. EN ISO 14175							