



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	PA PB PC				
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	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V
	As Welded	500	620	20	-40°C 80 -60°C 60
					Hardness HRc

REDRYING

Not required

GAS ACC. EN ISO 14175