



# CEWELD S3 Mo

<b>TYPE</b>	Solid wire for submerged arc welding with 0,5% Mo										
<b>ANWENDUNGEN</b>	Heat, creep-resistant and fine grain steel for working temperatures up to 500°C. Often used for pipe welding (X70).										
<b>EIGENSCHAFTEN</b>	Increased yield and impact strength due to high manganese content, excellent welding properties in combination with FL 851 and FL 155										
<b>KLASSIFIKATION</b>	<table border="0"> <tr> <td>AWS</td> <td>A 5.23: EA4</td> </tr> <tr> <td>EN ISO</td> <td>14171-A: S3Mo, 24598-A: S MnMo</td> </tr> <tr> <td>W.Nr.</td> <td>1.5426</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>3</td> </tr> </table>	AWS	A 5.23: EA4	EN ISO	14171-A: S3Mo, 24598-A: S MnMo	W.Nr.	1.5426	F-nr	6	FM	3
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W.Nr.	1.5426										
F-nr	6										
FM	3										
<b>GEEIGNET FÜR</b>	S550GD, S355JO, E335, P285NH, P310GH, S355JOCu, 16Mo3, P355N - P460N, P355NH - P460NH										

**ZULASSUNGEN** CE

**SCHWEISSPOSITIONEN**



**TYPISCHE CHEMISCHE ANALYSE DES FÜLLMETALLS (%)**

C	Si	Mn	P	S	Mo
0.12	0.15	1.6	0.015	0.015	0.5

**MECHANISCHE GÜTEWERTE**

Heat Treatment	R <sub>PO,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness
				0°C	-20°C	-40°C	
As Welded	550	660	24	95	65	50	HRc
580°C±15°C 2h	460	650	26	70	100	50	HRc

**RÜCKTROCKNUNG** Not required

**GAS ACC. EN ISO 14175**