



# CEWELD S3 Mo

|                   |                                                                                                                                                                                                                        |
|-------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| TYPE              | Solid wire for submerged arc welding with 0,5% Mo                                                                                                                                                                      |
| APPLICATIONS      | Heat, creep-resistant and fine grain steel for working temperatures up to 500°C. Often used for pipe welding (X70).                                                                                                    |
| PROPERTIES        | Increased yield and impact strength due to high manganese content, excellent welding properties in combination with FL 851 and FL 155                                                                                  |
| CLASSIFICATION    | <div> <div>AWS</div> <div>EN ISO</div> <div>W.Nr.</div> <div>F-nr</div> <div>FM</div> </div> <div> <div>A 5.23: EA4</div> <div>14171-A: S3Mo, 24598-A: S MnMo</div> <div>1.5426</div> <div>6</div> <div>3</div> </div> |
| SUITABLE FOR      | S550GD, S355JO, E335, P285NH, P310GH, S355JOCu, 16Mo3, P355N - P460N, P355NH - P460NH                                                                                                                                  |
| APPROVALS         | CE                                                                                                                                                                                                                     |
| WELDING POSITIONS | <div> <div>PA</div> <div>PB</div> <div>PC</div> </div>                                                                                                                                                                 |

## TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

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

## MECHANICAL PROPERTIES

| Heat Treatment | R <sub>P0,2</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      |

REDRYING Not required

GAS ACC. EN ISO 14175