



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.						
PROPRIÉTÉS	S3 is a Solid wire for CMn and mild steels with yield strength up to ~460 MPa Typical with FL 155 Flux.						
CLASSIFICATION	AWS EN ISO F-nr FM	A 5.17: EH10K, A 5.23: EH10K 14171-A: S3 6 1					
CONVIENT POUR	S275N-S420N, S275M-S420M, Fine grain P355N/S355NL-P460M/S460NL Shipbuilding grades A-E, AH40-EH40, Boiler steels P235GH-P355GH.						
AGRÉMENTS	CE						
POSITIONS DE SOUDAGE	 PA  PB  PC						
ANALYSE CHIMIQUE TYPIQUE DU MÉTAL D'APPORT (%)	C	Si	Mn	P	S		
	0.1	0.1	1.5	0.015	0.015		
PROPRIÉTÉS MÉCANIQUES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
	As Welded	500	620	20	-40°C	-60°C	
					80	60	HRc
ETUVAGE	Not required						
GAS ACC. EN ISO 14175							