



# CEWELD S3

<b>TYPE</b>	Solid drawn copper coated wire for the SAW process								
<b>ANWENDUNGEN</b>	Pipe work; offshore, pressure vessels, bridge, crane building, apparatus, and steam turbine construction.								
<b>EIGENSCHAFTEN</b>	S3 is a Solid wire for CMn and mild steels with yield strength up to ~460 MPa Typical with FL 155 Flux.								
<b>KLASSIFIKATION</b>	<table border="0"> <tr> <td>AWS</td> <td>A 5.17: EH10K</td> </tr> <tr> <td>EN ISO</td> <td>14171-A: S3</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>1</td> </tr> </table>	AWS	A 5.17: EH10K	EN ISO	14171-A: S3	F-nr	6	FM	1
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<b>GEEIGNET FÜR</b>	S275N-S420N, S275M-S420M, Fine grain P355N/S355NL-P460M/S460NL Shipbuilding grades A-E, AH40-EH40, Boiler steels P235GH-P355GH.								

**ZULASSUNGEN** CE

**SCHWEISSPOSITIONEN**



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

C	Si	Mn	P	S
0.1	0.1	1.5	0.015	0.015

**MECHANISCHE GÜTEWERTE**

Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
				-40°C	-60°C	
As Welded	500	620	20	80	60	HRc

**RÜCKTROCKNUNG** Not required

**GAS ACC. EN ISO 14175**