

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

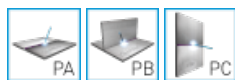
CLASSIFICATION

AWS	A 5.23: EA4
EN ISO	14171-A: S3Mo
W.Nr.	1.5426
F-nr	6
FM	3

SUITABLE FOR S550GD, S355JO, E335, P285NH, P310GH, S355JOCu, 16Mo3, P355N - P460N, P355NH - P460NH

APPROVALS CE

WELDING POSITIONS



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 _{PO,2} (MPa)	R _m (MPa)	A ₅ (%)	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