



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.					
PROPERTIES	S3 is a Solid wire for CMn and mild steels with yield strength up to ~460 MPa Typical with FL 155 Flux.					
CLASSIFICATION	AWS	A 5.17: EH10K, A 5.23: EH10K				
	EN ISO	14171-A: S3				
	F-nr	6				
	FM	1				
SUITABLE FOR	S275N-S420N, S275M-S420M, Fine grain P355N/S355NL-P460M/S460NL Shipbuilding grades A-E, AH40-EH40, Boiler steels P235GH-P355GH.					
APPROVALS	CE					
WELDING POSITIONS	PAPBPC					
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	P	S	
	0.1	0.1	1.5	0.015	0.015	
MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V	Hardness
					-40°C	-60°C
	As Welded	500	620	20	80	60
						HRc
REDRYING	Not required					
GAS ACC. EN ISO 14175						