



# CEWELD S3 Mo

<b>TYPE</b>	Solid wire for submerged arc welding with 0,5% Mo	
<b>APPLICATIONS</b>	Heat, creep-resistant and fine grain steel for working temperatures up to 500°C. Often used for pipe welding (X70).	
<b>PROPRIÉTÉS</b>	Increased yield and impact strength due to high manganese content, excellent welding properties in combination with FL 851 and FL 155	
<b>CLASSIFICATION</b>	AWS	A 5.23: EA4
	EN ISO	14171-A: S3Mo
	W.Nr.	1.5426
	F-nr	6
	FM	3

**CONVIENT POUR** S550GD, S355JO, E335, P285NH, P310GH, S355JOCu, 16Mo3, P355N - P460N, P355NH - P460NH

**AGRÉMENTS** CE

**POSITIONS DE SOUDAGE**

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

PROPRIÉTÉS MÉCANIQUES	Heat Treatment	R <sub>PO,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

**ETUVAGE** Not required

**GAS ACC. EN ISO 14175**