

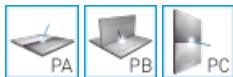


CEWELD S3

TYPE	Solid drawn copper coated wire for the SAW process	
ANWENDUNGEN	Pipe work; offshore, pressure vessels, bridge, crane building, apparatus, and steam turbine construction.	
EIGENSCHAFTEN	S3 is a Solid wire for CMn and mild steels with yield strength up to ~460 MPa Typical with FL 155 Flux.	
KLASSIFIKATION	AWS	A 5.17: EH10K
	EN ISO	14171-A: S3
	F-nr	6
	FM	1
GEEIGNET FÜR	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 _{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

RÜCKTROCKNUNG Not required

GAS ACC. EN ISO 14175