CEWELD S3Si

certilas® THE FILLER METAL SPECIALIST

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

Excellent mechanical strength and welding properties due to a increased manganese and silicon content. S3Si is best to be used with FL 155 high basic agglomerated flux to obtain neutral action on metallurgical chemistry and excellent subzero impact properties down to -60°C.

CLASSIFICATION

AWS	A 5.17: EH12K
EN ISO	14171-A: S3Si
W.Nr.	6

SUITABLE FOR

Materials	**DIN**	**EN**	**ASTM**
shipbuilding	A, B, D, E, AH 32 - EH 36	same	Typical
Unalloyed steels	St 33, St 37-2 - St 52-3	S185 - S355	A 258 / A 516
boiler steels	H I, H III, 17Mn4, 19Mn5	P235GH, P355GH	A 662 / A 387
pipe steels	St 35.8, St 45.8	P235T1/T2, P460NL2	A 738 / A 612
-	StE 210.7 TM, StE 445.7 TM	L210 - L445MB	A 299
Fine grain steels	StE 255 to StE 460	S235 - S460QL1	-
API-standard	X 42, X65, X 70	X 42, X65, X 70	-

APPROVALS

DNV

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	P	S
0.1	0.35	1.75	0.015	0.015

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V			Hardness
				RT	-40°C	-60°C	
As Welded	485	580	27	120	100	60	HRc

REDRYING

Not required

GAS ACC. EN ISO 14175

CEWELD S3Si

S3SI 2,4MM

Packaging	KG/unit	EanCode
Drum	300	8720663404510
K-415	25	8720663404503

S3SI 3,2MM

Packaging	KG/unit	EanCode
K-415	27	8720663404527

S3SI 4,0MM

Packaging	KG/unit	EanCode
K-415	25	8720663404534