



# CEWELD S3 NiMo1

|                |                                                                                                                                                                                                                                           |                                           |  |
|----------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------|--|
| TYPE           | Solid wire for submerged arc welding process for welding HSLA structural steels                                                                                                                                                           |                                           |  |
| ANWENDUNGEN    | Heavy construction, lifting, platforms, jack-ups, towers, crane building, machinery etc.                                                                                                                                                  |                                           |  |
| EIGENSCHAFTEN  | High strength weld deposit with good impact properties down to -60°C. S3 NiMo1 can be used in combination with FL 851 and FL 155, both fluxes offer low hydrogen content and excellent weldability in multi layer welding and narrow gap. |                                           |  |
| KLASSIFIKATION | AWS<br>EN ISO<br>F-nr<br>FM                                                                                                                                                                                                               | A 5.23: EF3<br>14171-A: S3Ni1Mo<br>6<br>1 |  |
| GEEIGNET FÜR   | S550QL1, fine grain steels, X70, X80, AISI 4130, 4140, 8630, 25CrMo4, 42CrMo4, 1.7218, 1.7228                                                                                                                                             |                                           |  |
| ZULASSUNGEN    | CE, TÜV: (12523)                                                                                                                                                                                                                          |                                           |  |

SCHWEISSPOSITIONEN



TYPISCHE CHEMISCHE  
ANALYSE DES  
FÜLLMETALLS (%)

| C    | Si  | Mn   | P     | S     | Ni  | Mo   |
|------|-----|------|-------|-------|-----|------|
| 0.12 | 0.2 | 1.75 | 0.015 | 0.015 | 0.9 | 0.55 |

MECHANISCHE GÜTEWERTE

| Heat Treatment | R <sub>P0.2</sub><br>(MPa) | R <sub>m</sub><br>(MPa) | A <sub>5</sub><br>(%) | Impact Energy (J) ISO-V |       |       | Hardness |
|----------------|----------------------------|-------------------------|-----------------------|-------------------------|-------|-------|----------|
|                |                            |                         |                       | -20°C                   | -40°C | -60°C |          |
| As Welded      | 610                        | 700                     | 23                    | 120                     | 100   | 60    | HRc      |

RÜCKTROCKNUNG Not required

GAS ACC. EN ISO 14175



# CEWELD S3 NiMo1

S3 NIM01 2,4MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| K-415     | 25      | 8720663404541 |

S3 NIM01 3,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| K-415     | 25      | 8720663404558 |

S3 NIM01 4,0MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| K-415     | 25      | 8720663404565 |