



# 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, A 5.23: 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                             | <div>PAPBPC</div> |                              |                      |                    |                         |       |          |
| TYPISCHE CHEMISCHE ANALYSE DES FÜLLMETALLS (%) | C                                                                                                                                                                                                                                                                    | Si                           | Mn                   | P                  | S                       |       |          |
|                                                | 0.1                                                                                                                                                                                                                                                                  | 0.1                          | 1.5                  | 0.015              | 0.015                   |       |          |
| MECHANISCHE GÜTEWERTE                          | Heat Treatment                                                                                                                                                                                                                                                       | R <sub>P0,2</sub> (MPa)      | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |       | Hardness |
|                                                | As Welded                                                                                                                                                                                                                                                            | 500                          | 620                  | 20                 | -40°C                   | -60°C |          |
|                                                |                                                                                                                                                                                                                                                                      |                              |                      |                    | 80                      | 60    | HRc      |
| RÜCKTROCKNUNG                                  | Not required                                                                                                                                                                                                                                                         |                              |                      |                    |                         |       |          |
| GAS ACC. EN ISO 14175                          |                                                                                                                                                                                                                                                                      |                              |                      |                    |                         |       |          |