



CEWELD S3 Mo

TYPE	Solid wire for submerged arc welding with 0,5% Mo
APPLICATIONS	Heat, creep-resistant and fine grain steel for working temperatures up to 500°C. Often used for pipe welding (X70).
PROPERTIES	Increased yield and impact strength due to high manganese content, excellent welding properties in combination with FL 851 and FL 155
CLASSIFICATION	AWS EN ISO W.Nr. F-nr FM A 5.23: EA4 14171-A: S3Mo, 24598-A: S MnMo 1.5426 6 3
SUITABLE FOR	S550GD, S355JO, E335, P285NH, P310GH, S355JOCu, 16Mo3, P355N - P460N, P355NH - P460NH
APPROVALS	CE
WELDING POSITIONS	PA PB PC

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

MECHANICAL PROPERTIES

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	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

REDRYING Not required

GAS ACC. EN ISO 14175