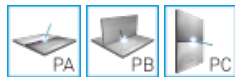


CEWELD S3 Mo

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	A 5.23: EA4	
	EN ISO	14171-A: S3Mo	
	EN ISO	24598-A: S MnMo	
	F-nr	6	
	FM	3	
	W.Nr.	1.5426	
SUITABLE FOR	S550GD, S355JO, E335, P285NH, P310GH, S355JOCu, 16Mo3, P355N - P460N, P355NH - P460NH		

APPROVALS CE

WELDING POSITIONS



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

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{P0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V		
				0°C	-20°C	-40°C
As Welded /	550	660	24	95	65	50
580°C±15°C / 2h	460	650	26	100	70	50

REDRYING TEMPERATURE Not required

GAS ACCORDING EN 14175