



# CEWELD S3Si

<b>TYPE</b>	Solid drawn copper coated wire for the SAW process		
<b>APPLICATIONS</b>	Pipe work; offshore, pressure vessels, bridge, crane building, apparatus, and steam turbine construction.		
<b>PROPERTIES</b>	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.		
<b>CLASSIFICATION</b>	AWS	A 5.17: EH12K	
	AWS	A 5.23: EH12K	
	EN ISO	14171-A: S3Si	
	F-nr	6	
	FM	1	
	W.Nr.	1.0496	

<b>SUITABLE FOR</b>	<b>Materials</b>	<b>DIN</b>	<b>EN</b>	<b>ASTM</b>
	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 Lloyds

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)**

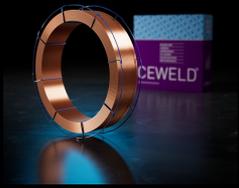
C	Si	Mn	P	S
0.1	0.35	1.75	0.015	0.015

**ALL WELD MECHANICAL PROPERTIES**

Heat Treatment	R <sub>P0,2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)	RT	Impact Energy (J) ISO-V	
					-40°C	-60°C
As Welded /	485	580	27	120	100	60

**REDRYING TEMPERATURE** Not required

**GAS ACCORDING EN 14175**



# CEWELD S3Si

S3Si 2,4MM

Type	KG/unit	EANCode
Drum	300	8720663404510
K-415	25	8720663404503

S3Si 3,2MM

Type	KG/unit	EANCode
K-415	27	8720663404527

S3Si 4,0MM

Type	KG/unit	EANCode
K-415	25	8720663404534