




CEWELD S3

TYPE	Solid drawn copper coated wire for the SAW process					
APPLICATIONS	Pipe work; offshore, pressure vessels, bridge, crane building, apparatus, and steam turbine construction.					
PROPERTIES	S3 is a Solid wire for CMn and mild steels with yield strength up to ~460 MPa Typical with FL 155 Flux.					
CLASSIFICATION	AWS	A 5.17: EH10K				
	AWS	A 5.23: EH10K				
	EN ISO	14171-A: S3				
	F-nr	6				
	FM	1				
SUITABLE FOR	S275N-S420N, S275M-S420M, Fine grain P355N/S355NL-P460M/S460NL Shipbuilding grades A-E, AH40-EH40, Boiler steels P235GH-P355GH.					
APPROVALS	CE					
WELDING POSITIONS	<div>PAPBPC</div>					
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	P	S	
	0.1	0.1	1.5	0.015	0.015	
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} MPa	R _m MPa	A5 (%)	Impact Energy (J) ISO-V	
	As Welded /	500	620	20	-40°C 80	-60°C 60
REDRYING TEMPERATURE	Not required					
GAS ACCORDING EN 14175						