



# CEWELD S3Si

<b>TYPE</b>	Solid drawn copper coated wire for the SAW process	
<b>ANWENDUNGEN</b>	Pipe work; offshore, pressure vessels, bridge, crane building, apparatus, and steam turbine construction.	
<b>EIGENSCHAFTEN</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>KLASSIFIKATION</b>	AWS EN ISO W.Nr.	A 5.17: EH12K 14171-A: S3Si 6

<b>GEEIGNET FÜR</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	-

**ZULASSUNGEN** DNV

**SCHWEISSPOSITIONEN**



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

C	Si	Mn	P	S
0.1	0.35	1.75	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
				RT	-40°C	-60°C	
As Welded	485	580	27	120	100	60	HRc

**RÜCKTROCKNUNG** Not required

**GAS ACC. EN ISO 14175**



# CEWELD S3Si

## S3Si 2,4MM

Packaging	KG/unit	EanCode
Drum	300	8720663404510
K-415	25	8720663404503

## S3Si 3,2MM

Packaging	KG/unit	EanCode
K-415	27	8720663404527

## S3Si 4,0MM

Packaging	KG/unit	EanCode
K-415	25	8720663404534