



# CEWELD S3

**TYPE** Solid drawn copper coated wire for the SAW process

**ANWENDUNGEN** Pipe work; offshore, pressure vessels, bridge, crane building, apparatus, and steam turbine construction.

**EIGENSCHAFTEN** S3 is a Solid wire for CMn and mild steels with yield strength up to ~460 MPa Typical with FL 155 Flux.

**KLASSIFIKATION** AWS A 5.17: EH10K  
EN ISO 14171-A: S3  
F-nr 6  
FM 1

**GEEIGNET FÜR** S275N-S420N, S275M-S420M, Fine grain P355N/S355NL-P460M/S460NL Shipbuilding grades A-E, AH40-EH40, Boiler steels P235GH-P355GH.

**ZULASSUNGEN** CE

**SCHWEISSPOSITIONEN**



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

C	Si	Mn	P	S
0.1	0.1	1.5	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
				-40°C	-60°C	
As Welded	500	620	20	80	60	HRc

**RÜCKTROCKNUNG** Not required

**GAS ACC. EN ISO 14175**