

S3 Mo

CATEGORY SAW Submerged arc

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 188F](#) and [FL 915](#)

CLASSIFICATION

AWS	A 5.23: EA 4
EN ISO	14171-A: S3Mo
DIN: W.Nr.	1.5426
DIN	8575: S3Mo

SUITABLE FOR S550GD, S355JO, E335, P285NH, P310GH, S355JOCu, 16Mo3, P355N - P460N, P355NH - P460NH

APPROVALS CE approved

WELDING POSITIONS:



FILLER METAL ANALYSIS % (TYPICAL VALUES)

C	Mn	Si	Cr	Ni	Mo
0.12	1.52	0.15	-	-	0.52

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
				-20°C	-40°C	-60°C	
AW	>470	>550	>24	>80	>47		

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool / Drum	kg / pallet
1,6			K-415 / Drum	25 / 300	
2,0			K-415 / Drum	25 / 300	
2,4			K-415 / Drum	25 / 300	
3,2			K-415 / Drum	25 / 300	
4,0			K-415 / drum	25 / 300	

REDRYING TEMPERATURE not required