

CATEGORY SAW Arc Submerged

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:



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 <sub>p0.2</sub><br>MPa | R <sub>m</sub><br>MPa | A <sub>5</sub><br>(%) | Impact Energy (J) ISO-V |       |
|----------------|--------------------------|-----------------------|-----------------------|-------------------------|-------|
|                |                          |                       |                       | -40°C                   | -60°C |
| As Welded /    | 500                      | 620                   | 20                    | 80                      | 60    |

WELDING PARAMETERS / PACKING

REDRYING TEMPERATURE Not required

GAS ACCORDING EN 14175