

CATEGORY SAW Arc Submerged

TYPE Solid wire for submerged arc welding with high Manganese content and 0,5% Mo.

APPLICATIONS Fine grain steels for yield strength applications exceeding 500 MPa. Often used for pipe welding (X70-X80) when Mn. and Si. content is low..

PROPERTIES High Manganese and Silicon content for improved de-oxidation and strength, excellent wetting for increased welding speed with corresponding flux. Suitable fluxes are depending on the weld metal requirements, in most cases CEWELD® FL 155 gives excellent results.

CLASSIFICATION	AWS	A 5.23: EA3K
	EN ISO	14341-A: G4Mo
	F-nr	6
	FM	3

SUITABLE FOR Pipe steels acc. to ISO 3183, EN 10208 and API-5: L360N/X52 to L555Q/X80

APPROVALS No Approvals Found

WELDING POSITIONS:



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	P	S	Mo
0.1	0.7	1.8	0.015	0.015	0.5

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V			
				-20°C	-40°C	0°C	-30°C
As Welded / 580°C±15°C /2h	550	680	20	60	50	80	60

WELDING PARAMETERS / PACKING

WELDING PARAMETERS		WELDING PARAMETERS		WELDING PARAMETERS		PACKING	PACKING
D (MM)	VOLTAGE (V)		CURRENT (A)		SPOOLING TYPE	KG / SPOOL / DRUM	
2.0	28-30		250-400		K-415 / DRUM	25 / 300	
2.4	28-32		300-600		K-415 / DRUM	25 / 300	
3.2	28-34		350-700		K-415 / DRUM	25 / 300	
4.0	28-36		450-800		K-415 / DRUM	25 / 300	

REDRYING TEMPERATURE Not required

GAS ACCORDING EN 14175