

CATEGORY	SAW Arc Submerged		
TYPE	Solid wire for submerged arc welding process for welding HSLA structural steels		
APPLICATIONS	Heavy construction, lifting, platforms, jack-ups, towers, crane building, machinery etc.		
PROPERTIES	High strength weld deposit with good impact properties down to -60°C. S3 NiMo1 can be used in combination with FL 851 and FL 155, both fluxes offer low hydrogen content and excellent weldability in multi layer welding and narrow gap.		
CLASSIFICATION	AWS	A 5.23: EF3	
	EN ISO	14171-A: S3Ni1Mo	
	F-nr	6	
	FM	1	
SUITABLE FOR	S550QL1, fine grain steels, X70, X80, AISI 4130, 4140, 8630, 25CrMo4, 42CrMo4, 1.7218, 1.7228		
APPROVALS	CE TÜV (12523.00)		

WELDING POSITIONS:



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	P	S	Ni	Mo
0.12	0.2	1.75	0.015	0.015	0.9	0.55

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V		
				-20°C	-40°C	-60°C
As Welded /	610	700	23	120	100	60

WELDING PARAMETERS / PACKING

WELDING PARAMETERS	WELDING PARAMETERS	PACKING	PACKING
D (MM)	CURRENT RANGE (A)	SPOOLING TYPE	KG / SPOOL / DRUM
2.0	200-500	K-435 / DRUMS	20-30 / 300
2.4	300-600	K-435 / DRUMS	20-30 / 300
3.2	350-700	K-435 / DRUMS	20-30 / 300
4.0	450-800	K-435 / DRUMS	20-30 / 300

REDRYING TEMPERATURE	Not required
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GAS ACCORDING EN 14175