



CEWELD S3 NiMoCr

TYPE	Submerged arc welding wire for high strength fine grain steels with >690 MPa yield strength.							
APPLICATIONS	Applications will be found in the offshore industry, shipbuilding, pressure vessels, earthmoving equipment, cranes and general structural fabrication.							
PROPERTIES	Welding procedure (including preheat temperature, interpass temperature and PWHT) will be dependent on the base material being welded, including its thickness, and any applicable design codes. Remarkable crack resistant weld metal in combination with very low hydrogen content. Therefore, suitable for the economic processing of high-strength and low temperature fine grained structural steels. Excellent welding properties in combination with FL 155 high basic flux even in narrow gaps. To obtain optimum mechanical properties the heat input should be kept below 15 kJ/cm and interpass temperature between 100 and 150°C.							
CLASSIFICATION	AWS	A 5.23: EM4~						
	EN ISO	26304-A: S3Ni2,5CrMo						
	F-nr	6						
	FM	2						
SUITABLE FOR	S690, X80, X90, X100, S690QL1, Weldox 700, Dilimax, Naxtra 70, 10CrMo9-10, 16NiCrMo12-6, high strenght steels with yield >690N/mm2, S500Q-S690Q, S500QL-S690QL, P500Q-P690Q, P500QL1-ASTM: A514, A517. HY80, HY100, Q1(N), Oceanfit 100, Oceanfit 690							
APPROVALS	CE, Lloyds							
WELDING POSITIONS	 PA  PB  PC							
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	P	S	Cr	Ni	Mo
	0.09	0.2	1.6	0.01	0.01	0.3	2.1	0.6
MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness	
					-40°C	-60°C		
	As Welded	710	780	17	80	75	HRc	
REDRYING	Not required							
GAS ACC. EN ISO 14175								



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S3 NIMOCR 2,0MM

Packaging	KG/unit	EanCode
Drum	300	8720663404589
K-415	27	8720663404572

S3 NIMOCR 4,0MM

Packaging	KG/unit	EanCode
K-415	25	8720663404596