



CEWELD S3 Mo

TYPE

APPLICATIONS

PROPRIÉTÉS

CLASSIFICATION

CONVIENT POUR

AGRÉMENTS

POSITIONS DE SOUDAGE

ANALYSE CHIMIQUE
TYPIQUE DU MÉTAL
D'APPORT (%)

PROPRIÉTÉS MÉCANIQUES

ETUVAGE

GAS ACC. EN ISO 14175

Solid wire for submerged arc welding with 0,5% Mo

Heat, creep-resistant and fine grain steel for working temperatures up to 500°C. Often used for pipe welding (X70).

Increased yield and impact strength due to high manganese content, excellent welding properties in combination with FL 851 and FL 155

AWS

EN ISO

W.Nr.

F-nr

FM

A 5.23: EA4

14171-A: S3Mo, 24598-A: S MnMo

1.5426

6

3

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

CE

PA

PB

PC

C	Si	Mn	P	S	Mo
0.12	0.15	1.6	0.015	0.015	0.5

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness
				0°C	-20°C	-40°C	
As Welded	550	660	24	95	65	50	HRc
580°C±15°C 2h	460	650	26	70	100	50	HRc

Not required