



CEWELD S3 Mo

TYPE	Solid wire for submerged arc welding with 0,5% Mo		
ANWENDUNGEN	Heat, creep-resistant and fine grain steel for working temperatures up to 500°C. Often used for pipe welding (X70).		
EIGENSCHAFTEN	Increased yield and impact strength due to high manganese content, excellent welding properties in combination with FL 851 and FL 155		
KLASSIFIKATION	AWS	A 5.23: EA4	
	EN ISO	14171-A: S3Mo, 24598-A: S MnMo	
	W.Nr.	1.5426	
	F-nr	6	
	FM	3	
GEEIGNET FÜR	S550GD, S355JO, E335, P285NH, P310GH, S355JOCu, 16Mo3, P355N - P460N, P355NH - P460NH		
ZULASSUNGEN	CE		
SCHWEISSPOSITIONEN	  		

TYPISCHE CHEMISCHE ANALYSE DES FÜLLMETALLS (%)	C	Si	Mn	P	S	Mo
	0.12	0.15	1.6	0.015	0.015	0.5

MECHANISCHE GÜTEWERTE	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	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

RÜCKTROCKNUNG Not required

GAS ACC. EN ISO 14175