



# CEWELD S3 Mo

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

**ZULASSUNGEN** CE

**SCHWEISSPOSITIONEN**



**TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)**

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

**MECHANISCHE GÜTEWERTE**

Heat Treatment	R <sub>PO,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	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