



CEWELD S3Si

TYPE	Solid drawn copper coated wire for the SAW process	
ANWENDUNGEN	Pipe work; offshore, pressure vessels, bridge, crane building, apparatus, and steam turbine construction.	
EIGENSCHAFTEN	Excellent mechanical strength and welding properties due to a increased manganese and silicon content. S3Si is best to be used with FL 155 high basic agglomerated flux to obtain neutral action on metallurgical chemistry and excellent subzero impact properties down to -60°C.	
KLASSIFIKATION	AWS EN ISO W.Nr.	A 5.17: EH12K 14171-A: S3Si 6

GEEIGNET FÜR	Materials	DIN	EN	ASTM
	shipbuilding	A, B, D, E, AH 32 - EH 36	same	Typical
	Unalloyed steels	St 33, St 37-2 - St 52-3	S185 - S355	A 258 / A 516
	boiler steels	H I, H III, 17Mn4, 19Mn5	P235GH, P355GH	A 662 / A 387
	pipe steels	St 35.8, St 45.8	P235T1/T2, P460NL2	A 738 / A 612
	-	StE 210.7 TM, StE 445.7 TM	L210 - L445MB	A 299
	Fine grain steels	StE 255 to StE 460	S235 - S460QL1	-
	API-standard	X 42, X65, X 70	X 42, X65, X 70	-

ZULASSUNGEN DNV

SCHWEISSPOSITIONEN



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	P	S
	0.1	0.35	1.75	0.015	0.015

MECHANISCHE GÜTEWERTE	Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness
					RT	-40°C	-60°C	
	As Welded	485	580	27	120	100	60	HRc

RÜCKTROCKNUNG Not required

GAS ACC. EN ISO 14175



CEWELD S3Si

S3Si 2,4MM

Packaging	KG/unit	EanCode
Drum	300	8720663404510
K-415	25	8720663404503

S3Si 3,2MM

Packaging	KG/unit	EanCode
K-415	27	8720663404527

S3Si 4,0MM

Packaging	KG/unit	EanCode
K-415	25	8720663404534