



# CEWELD S3 NiMo1

**TYPE** Solid wire for submerged arc welding process for welding HSLA structural steels

**APPLICATIONS** Heavy construction, lifting, platforms, jack-ups, towers, crane building, machinery etc.

**PROPERTIES** High strength weld deposit with good impact properties down to -60°C. S3 NiMo1 can be used in combination with FL 851 and FL 155, both fluxes offer low hydrogen content and excellent weldability in multi layer welding and narrow gab.

**CLASSIFICATION**

AWS	A 5.23: EF3
EN ISO	14171-A: S3Ni1Mo
F-nr	6
FM	1

**SUITABLE FOR** S550QL1, fine grain steels, X70, X80, AISI 4130, 4140, 8630, 25CrMo4, 42CrMo4, 1.7218, 1.7228

**APPROVALS** CE, TÜV: 12523.00

**WELDING POSITIONS**



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

C	Si	Mn	P	S	Ni	Mo
0.12	0.2	1.75	0.015	0.015	0.9	0.55

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>P0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness
				-20°C	-40°C	-60°C	
As Welded	610	700	23	120	100	60	HRc

**REDRYING** Not required

**GAS ACC. EN ISO 14175**



# CEWELD S3 NiMo1

S3 NIM01 2,4MM

Packaging	KG/unit	EanCode
K-415	25	8720663404541

S3 NIM01 3,2MM

Packaging	KG/unit	EanCode
K-415	25	8720663404558

S3 NIM01 4,0MM

Packaging	KG/unit	EanCode
K-415	25	8720663404565