



CEWELD S3 NiMo1

TYPE	Solid wire for submerged arc welding process for welding HSLA structural steels		
ANWENDUNGEN	Heavy construction, lifting, platforms, jack-ups, towers, crane building, machinery etc.		
EIGENSCHAFTEN	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 gap.		
KLASSIFIKATION	AWS EN ISO F-nr FM	A 5.23: EF3 14171-A: S3Ni1Mo 6 1	
GEEIGNET FÜR	S550QL1, fine grain steels, X70, X80, AISI 4130, 4140, 8630, 25CrMo4, 42CrMo4, 1.7218, 1.7228		
ZULASSUNGEN	CE, TÜV: (12523)		

SCHWEISSPOSITIONEN



TYPISCHE CHEMISCHE ANALYSE DES FÜLLMETALLS (%)

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

MECHANISCHE GÜTEWERTE

Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness
				-20°C	-40°C	-60°C	
As Welded	610	700	23	120	100	60	HRc

RÜCKTROCKNUNG Not required

GAS ACC. EN ISO 14175



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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