



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 gap.

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)

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 _{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

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