

CEWELD S3 Ni1Mo1/4

TYPE	SAW NiMo-alloyed wire for high strength structural steels. (< 500 MPa)
APPLICATIONS	The Applications will be found in the offshore industry, pipe production, shipbuilding and general structural fabrication. For high strength quenched and tempered structural steels.
PROPRIÉTÉS	NiMo-alloyed solid wire electrode with higher Mn-content for submerged arc welding of high tensile pipe steels and high tensile fine grain steels. Especially suitable for low temperature applications because of low Mo-content. Best suitable if requirements for sour-gas environment are to match Ni < 1.0 %. Best Flux CEWELD FL 155 (ISO 14171-A: S 46 6 FB S3Ni1Mo0,2 / AWS 5.23: F8A8/P8-ENi5-Ni5)

CLASSIFICATION	AWS	A 5.23: ENi5
	EN ISO	14171-A: S3Ni1Mo0,2

CONVIENT POUR	Reh ≤ 500 MPa ISO 15608: 1.3, ~3.1, ~2.2, 2.1, 1.0580 to 1.0070, 1.8900 to 1.8905, 1.8930 to 1.8935, 1.8910 to 1.8915, 1.6217, 1.6210, 1.0481, 1.0482, 1.0551, 1.0553. S275N-S460N, S275NL-S460NL, S275M-S460M, S275ML-S460ML, P355N, P355NH, P460N, P460NH, P275NL1-P460NL1, P275NL2- P460NL2, L360NB, L415NB, L360MB-L450MB, L360QB-L450QB,~S500QL... ASTM A 203 Gr. D, E; A 350 Gr. LF1, LF2, LF3; A 420 Gr. WPL3, WPL6; A 516 Gr. 60, 65, 70; A 572 Gr. 42, 50, 55, 60, 65; A 633 Gr. A, D, E; A 662 Gr. A, B, C; A 707 Gr. L1, L2, L3; A 738 Gr. A; A 841 A, B, C; API 5 L X52, X60, X65, X52Q, X60Q, X65Q Oceanfit 52, Oceanfit 60, Oceanfit 65, Oceanfit 355, Oceanfit 420, Oceanfit 460, alform plate 460M; durostat 400, 450, 500, durostat B2
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AGRÉMENTS

POSITIONS DE SOUDAGE



ANALYSE CHIMIQUE TYPIQUE DU MÉTAL D'APPORT (%)

C	Si	Mn	P	S	Cr	Ni	Mo	Cu
0.1	0.15	1.5	0.005	0.002	0.04	0.9	0.25	0.2

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A5 (%)	Impact Energy (J) ISO-V				Hardness
				RT	-20°C	-40°C	-60°C	
580°C±15°C 10h	450	540	26	160	150	110	100	HRc
As Welded	490	580	26	160	140	120	100	HRc

ETUVAGE	Not required
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GAS ACC. EN ISO 14175