



# UP EF3

## Low Alloy Submerged Arc Wire

### Classification

AWS A 5.23: ERF3

ENISO 24598A: S3NiMo1

### Charateristics

Solid copper coated Wire for submerged arc welding, It is recommended for welding wire for high strength structural steels. content.

### Applications

For High strength low alloy Fine-grained steels with yield strength upto ~550MPa (80ksi). P460NL1, P460ML1, S460Q-S550Q, S460QL-S550QL, P460Q-P500Q, P460QL1- 500QL1. 15NiCuMoNb5-6-4, (1.6368) ASTM: A182 grade F36, A335 grade P36, A533, A537

### Typical Wire Composition (%)

C	Si	Mn	Ni	Mo	P	S
0.09	0.30	1.50	0.95	0.45	0.020	0.010

### All Weld Metal Mechanical Properties

Conditions	UTS R <sub>m</sub> (MPa)	YS R <sub>p0.2</sub> (MPa)	% Elg A=5d	Impact (kv) Temp. °C	J
AW UP BF 10	680	575	23	- 60	45

### Parameters

Process	Wire Ø (mm)	Current (A)	Voltage (V)	Travel Speed (cm/min)	Flux
UP/SAW DC +ve	2.40	200 - 400	25 - 28	45 - 55	UP LA 04
	3.20	300 - 500	25 - 28	45 - 55	UP LA05
	4.00	500 - 700	28 - 32	45 - 55	UP BF10

### Packing & Storage

25 kg Spool packed in Corrugated Cardboard Boxes. Wire to be Stored in dry conditions.

ind.1

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