



## SELECTARC UP S3

### Solid Wire for SAW

#### Classification

AWS A5.17 : EH10K  
ISO 14171-A : S3

Material N° : 1.0496

#### Applications

Ship building, Crane, Construction Steel, Vessel and Construction Equipment. Nuclear Power, Petrochemical & Off-shore sectors, Steam Generators.

Materials	DIN	EN	ASTM
Shipbuilding steels	A, B, D, E		A 131
Unalloyed structural steels	St 33, St 37-2 - St 52-3	S185, S235 - S355	A 106 / A 515 / A 714
boiler steels	HI, HII, 17Mn4 19 Mn 5 15Mo3 , 16Mo3	P235GH, P265GH 15Mo3 , 16Mo3	A 283 / A 285 / A 414 / A 662 / A 372
pipe steels	St 35.8, St 45.8 StE 210.7 TM-StE 415.7 TM	P235 T1/T2-P355 N L 210- L 320	A 369 / A 210 / A 106
fine grain structural steels	StE 255 to StE 460	S 255-S460	A 516/ A 255 / A 333 A 350 / A 612
Steels to API-standard	X 42 - X 60		

#### Typical Wire Composition (%)

C	Mn	Si	P	S	Fe
0.10	1.40	0.20	0.015	0.010	base

#### All Weld Metal Mechanical Properties (Typical)

Conditions / Flux	UTS	YS	% Elg A <sub>5</sub>	Impact (KV)	
	R <sub>m</sub> (MPa)	R <sub>p0.2</sub> (MPa)		Temp. °C	J
AW UP BF 10	595	480	26	-40	90
				-60	70
PWHT UP BF 10	520	400	29	-40	70
				-60	60

PWHT : After heat treatment at 590°C / 10hrs.

#### Welding Current & Instructions

Ø (mm)	Polarity	Current (A)	Voltage (V)	Stick out (mm)	Flux
2.4	= +	200 - 400	28 - 32	~ 24	UP LA 04 / UP La05 / UP BF 10
3.2	= +	300 - 500	28 - 32	~ 32	
4.0	= +	500 - 700	29 - 33	~ 40	

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