



UP S3Mo

Low Alloy Submerged Arc Wire

Classification

AWS A 5.23 : EA4

EN ISO 14171-A : S3Mo

Characteristics

Solid copper coated wire for submerged arc welding, It is Mo-alloyed wire with high Mn content recommended for welding of fine grain steels, pipe steels and heat resistance boiler & Pressure vessel Steels.

Applications

For High strength low alloy Fine-grained steels, heat resistant steels P460NL/S460NL to P500Q/S500QL, L360N/X52 to L555Q/X80, 16Mo 3/A204 grade A & A209 grade T1, P355GH/A516 grade 70 and S355J2G3/A572 grade 50.

Typical Wire Composition (%)

C	Si	Mn	Cr	Mo	Cu	P	S	Ni
0.10	0.14	1.60	0.04	0.50	0.09	0.014	0.012	0.02

All Weld Metal Mechanical Properties (Typical)

Conditions	UTS R _m (MPa)	YS R _{p0.2} (MPa)	% Elg A _{5d}	Impact (KV) Temp. ^o C J
AW	650	550	25	-20 ^o C 65 -30 ^o C 45

Welding Parameter

Process	Ø (mm)	Welding Parameters			Flux
		Current (A)	Voltage (V)	Speed cm/min	
SAW	2.4	200 - 400	25 - 28	45 - 55	UP LA04 UP LA05 UP BF10
	3.2	300 - 500	25 - 28	45 - 55	
	4.0	500 - 700	28 - 32	45 - 55	

Packing

Available in 25 kg Spool ; Drums packing