

Classifications

AWS A5.23 / SFA-5.23

EN ISO 14171-A

EG

S3Ni1,5Mo

Characteristics and typical fields of application

Union S 3 NiMo is a coppered solid wire for submerged arc welding of steel grades with higher strength and toughness. Especially suited for applications with PWHT like normalising.

Typical analysis

| | C | Si | Mn | Ni | Mo | S | P |
|-------|------|------|------|------|------|---------|---------|
| wt.-% | 0.09 | 0.10 | 1.60 | 1.50 | 0.45 | ≤ 0.012 | ≤ 0.012 |

Operating data

Dimension mm

3.0

4.0

Recommended SAW flux:

UV 418 TT UV 420 TTR

UV 420 TT UV 420 TTR-W

UV 421 TT UV 420 TT-LH

Approvals

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