

Submerged Arc Welding Wire for Low Alloyed Steels

Classification

EN ISO 14171 : S3Mo (LW-888 tozu ile S 46 5 FB S3Mo)
AWS A5.23 : EA4

General Description

AS S3Mo is copper coated and Mo-alloyed submerged arc welding wire designed particularly for welding of high impact resistant steels. It is used for the welding creep resistant and fine grained steels in operating temperatures up to 550 °C.

Chemical Composition (w%), Typical, Wire

C	Si	Mn	Mo
0.08	0.15	1.40	0.50
0.06 *	0.30 *	1.40 *	0.40 *

(*) Typical weld metal composition with flux LW 888

Mechanical Properties, Typical, All Weld Metal

Yield Strength	: 490 N/mm ²
Tensile Strength	: 590 N/mm ²
Elongation (L=5d)	: 29 %
Impact (ISO-V)	: 60 J (-40°C)

Materials to be Welded

	DIN	EN
General Structural Steels	St 33, St 34, St 37, St 44, St 44-2, St 44-3, St 52, St 52-3	S185, S235, S275, S355
Fine Grained Steels	StE 255 - StE 460 WStE 255 - WStE 460	S255N - S460N P255NH - P460NH
Pipe Materials	StE 320-7 - StE 415-7 StE 290-7 TM - StE 480-7 TM X42, X46, X52, X56, X60, X65, X70, X80 (API 5LX)	L320 - L415NB L290MB - L485MB -
Boiler and Pressure Vessel Steels	17 Mn 4, 19 Mn 5, 15 Mo 3 HI, HII, HIII	P295GH, P310GH, 16 Mo 3 P235GH, P265GH, P285NH
Elevated Temperature Steels	St 35-8, St 45-8	P235G1TH - P255G1TH
Ship Plates	A, B, C, D, E	-

Packing and Diameter Informations

Diameter	2.0	2.4	3.2	4.0	Spool Weight	Drum Weight
Submerged Arc Welding Wire	-	-	X	X	25 kg	350 / 650 kg