

## 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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