

Classifications

AWS A5.17 / SFA-5.17
EN ISO 14171-A

EH12K

S3Si

Characteristics and typical fields of application

Union S 3 Si is a coppered solid wire for submerged arc welding of general structural steel grades up to S235-S460.

Recommended SAW flux:

UV 309 P

UV 310 P

UV 400

UV 418 TT

UV 419 TT-W

UV 420 TTR

UV 422 TT-LH

Typical analysis

	C	Si	Mn
wt.-%	0.10	0.30	1.65

Operating data

Dimension mm

2.0

2.5

3.0

3.2

4.0

4.8

Approvals

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