UP EF3

Classification

AWS A5.23 : EF3 ISO 26304-A S3Ni1Mo

Description & Applications

Solid wire alloyed with Mn-Ni-Mo for submerged arc welding of high strength steels with yield strength up to 550MPa.

Main applications: Steel Construction, foundry, boilers…

Base materials:

Fine grain high strength steels:

EN	*ASTM*
P460NL1	A182 grade F36
P460ML1	A336 grade P36
S460Q	A533
P500Q	A537
S550QL1	API 5LX70, 75, 80

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	Al	P	S	Fe
Min	0.10	0.05	1.50		0.80	0.45					
Max	0.15	0.25	1.80	0.20	1.10	0.65	0.30	0.030	0.020	0.020	Rem.
Type	0.12	0.20	1.75	0.02	0.90	0.55	0.10	0.005	0.015	0.010	Rem.

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters				Flux
		Current (A)	Voltage (V)	Stick out (mm)	Speed (cm/min)	
SAW AC / =+	2.4 3.2 4.0	200 - 400 300 - 500 500 - 700	25 - 30 28 - 32 30 - 35	18 20 22	40 - 60 40 - 60 50 - 60	UP BF10

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