Selectarc WELDING

SELECTARC UP S3Si

Solid Wire for SAW

Classification

AWS A5.17 : EH12K ISO 14171-A : S3Si

Charateristics

Solid wire for submerged - arc welding

Applications

Ship, Crane, Steel, Vessel and Equipment construction

Materials	DIN	EN	ASTM
Shipbuilding Steels	A, B, D, AH 32 - EH 36		A 131
Unalloyed structural steels	St 33, St 37-2 - St 52-3	S185 - S355	A 106 / A 51S / A 714
boiler steels	HI, HII, 17Mn4 19 Mn 5 15Mo3 , 16Mo3	P235GH, P355GH 15Mo3 , 16Mo3	A 283 / A 285 / A 414 / A 662 / A 372
pipe steeels	St 35.8, St 45.8 StE 210.7 TM-StE 445.7 TM	P235 T1/T2-P355 N L 210- L 445	A 369 / A 210 / A 106
fine grain structural steels	StE 255 to StE 460	S 255-S460	A 516/ A 255 / A 333 A 350 / A 612
Steels to API-standard	X 42 - X 60		

Typical Wire Composition (%)

C	Mn	Si	P	S	Fe
0.10	1.40	0.30	0.015	0.010	base

All Weld Metal Mechanical Properties (Typical)

Conditions	UTS R_m (MPa)	YS $R_{p0.2}$ (MPa)	% Elg A_5	Impact (KV) Temp.°C	J
AW	568	465	23	-40	60
				-60	47

Welding Current & Instructions

Ø (mm)	Polarity	Current (A)	Voltage (V)	Stick out (mm)	Flux
2.4	= +	200 - 400	28 - 32	~ 24	UP LA 04 / UP LA 05
3.2	= +	300 - 500	28 - 32	~ 32	
4.0	= +	500 - 700	29 - 33	~ 40	

Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.