

S3 1Ni¼Mo (Sonder)

SAW wire for mild and low alloy steels

Product name	S3 1Ni¼Mo (Sonder)
Classification EN ISO	14171-A: S3Ni1Mo0.2
Material No.	-
Classification AWS	A5.23: ENi5
Approvals	-
Applications	Submerged arc welding wire for high strength quenched and tempered structural steels. Applications will be found in the offshore industry, shipbuilding and general structural fabrication.
Base materials	For high strength low alloy fine-grained steels with yield strengths up to ~500MPa (72ksi). API: 5L grades X60-X70. S450J2, S460N, P460QL1-P500QL1, P460QL2-P500QL2, S460QL-S500QL, S460QLN-S500QLN, P460QL1-P500QL1, P460QL2-P500QL2.
Typical analysis of wire, weight %	C: 0.10 Si: 0.22 Mn: 1.45 Ni: 0.90 Mo: 0.25
Typical heat treatment ⁽¹⁾	Welding procedure (including preheat temperature, interpass temperature and PWHT) will be dependent on the base material being welded, including its thickness, and any applicable design codes.
Mechanical properties of weld deposit ⁽²⁾	Mechanical properties will be dependent on the welding procedure and flux.
Other products	MIG/GMAW: A31 TIG/GTAW: A31

Notes (1) Application codes and project specifications should always be referred to for specific requirements.

(2) Actual mechanical properties will be dependent on specific welding procedure (including shielding gas, flux, PWHT etc) and should always be confirmed by approval of an appropriate welding procedure.