

### Standards

TS EN ISO 26304-A	: S3 Ni1Mo
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AWS A5.23	: EF3

### Chemical Composition of Welding Wire % (Typical)

C	Si	Mn	Mo	Ni
0.12	0.20	1.75	0.55	0.90

### Mechanical Properties

Sumerged Arc Flux	AWS A5.23	Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation ((L <sub>0</sub> =5d <sub>0</sub> ) (%))	Impact Strength ISO-V(J)	
					-20°C	-40°C
ELIFLUX BFF	F9 A4-EF3-F3	580	650	21	100	60

### Chemical Composition of Weld Metal - % (Typical)

Sumerged Arc Flux	C	Si	Mn	Mo	Ni
ELIFLUX BFF	0.09	0.25	1.65	0.55	0.90

### Typical Base Material Grades

- Pipe Steels : X52, X56, X60, X65, X70, X80, L360MB, L385M, L415MB, L450MB, L485MB, L555MB
- Fine-grained Steels: S550QL1 S380N, S500N, S380NL, S500NL
- Pressure Steels: 20 MnMoNi5-5

### Features and Applications

- S3NiMo1 is a Nickel-Molybdenum-Alloyed, copper-coated wire designed for submerged arc welding of structural steels and higher tensile steels

### Operating Data

Product Code	Diameter (mm) / (inch)		Weight (Kg)	Package Type
3010400273	2.4	3/32	25	K 435 *BIG PACK
3010400274	3.2	1/8	25	
3010400275	4.0	5/32	25	