

Standards

TS EN ISO 26304-A	: S 3 Ni2.5CrMo
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AWS A5.23	: EM4 (mod.)

Chemical Composition of Welding Wire % (Typical)

C	Si	Mn	Mo	Ni	Cr
0.11	0.17	1.40	0.55	2.40	0.70

Mechanical Properties

Submerged Arc Flux	AWS A5.23	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation ((Lo=5do) (%))	Impact Strength ISO-V(J)		
					-20°C	-40°C	-60°C
ELIFLUX BFF	F11A8-EM4 (mod.)-M4	740	850	20	90	85	min.27
ELIFLUX BAB-S	F11A4-EM4(mod.)-M4	735	855	18	70	60	---

Chemical Composition of Weld Metal - % (Typical)

Submerged Arc Flux	C	Si	Mn	Mo	Ni	Cr
ELIFLUX BFF	0.06	0.30	1.50	0.50	2.20	0.50
ELIFLUX BAB-S	0.05	0.65	1.80	0.48	2.05	0.35

Typical Base Material Grades

- Fine-grained steels: S550QL1, S690QL1

Features and Applications

- S3NiCrMo 2.5 is a CrNiMo alloyed, Copper-coated wire designed for submerged arc welding of high strength quenched, tempered structural steels and extra high tensile steels

Operating Data

Product Code	Diameter (mm) / (inch)		Weight (Kg)	Package Type
3010400291	2.4	3/32	25	K 435 *DRUM <small>* Packaging alternatives according to the order; 400 - 600 Kg</small>
3010400292	3.2	1/8	25	
3010400293	4.0	5/32	25	

Approvals: S3NiCrMo2.5: CE, SEPRO