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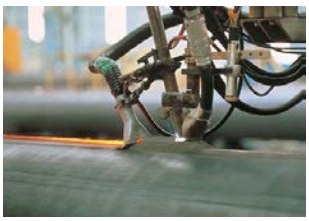
TECHNICAL SPECIFICATION
SUBMERGED ARC WELDING WIRE
PITTARC S3Mo

Document	SPP117
Revision	08 i
Date	18.09.2014
Page	1/1



1. DESCRIPTION

Submerged arc welding wire conforming standards ISO 14171-A-S3Mo and AWS A5.23 EA4 suitable to join common and Mo low alloy steels for construction, pressure vessels, pipes.

2. PRODUCT CHEMICAL COMPOSITION (%)

		C	Mn	Si	P	S	Cr	Ni	Mo	Cu	Al
PITTARC S3Mo	Min	0.08	1.30	0.05	-	-	-	-	0.45	-	-
	Max	0.15	1.70	0.20	0.025	0.025	0.15	0.15	0.65	0.30	0.03
AWS A5.23 EA4	Min	0.05	1.20	-	-	-	-	-	0.45	-	-
	Max	0.15	1.70	0.20	0.025	0.025	-	-	0.65	0.35	-
ISO 14171-A-S3Mo	Min	0.07	1.30	0.05	-	-	-	-	0.45	-	-
	Max	0.15	1,75	0.25	0.025	0.025	0.15	0.15	0.65	0.30	0.03

3. WIRE DIMENSIONS

Standard diameter (mm) : 1.6 ; 2.0 ; 2.4 ; 3.2 ; 4.0 ; 4.8
Permissible deviations : ISO 544

4. STANDARD PACKAGING :

Wire basket rim LC (ISO 544 B450) of 27kg net weight. Each spool sealed in a polyethylene airtight bag and packed into a cardboard box. 42 spools stacked onto a pallet secured by thermoplastic shrink-wrapping (120 x 80 cm, 1134kg net weight). Available cardboard drums of about 320kg net weight, each one stacked onto a pallet 110x110cm of about 1280kg total weight (4 drums), secured by thermoplastic shrink-wrapping. On request packaging available from 15 kg up to 900 kg.

5. STANDARD IDENTIFICATION

A label is attached to the inside of each spool or drums and to every box or outside of the drums mentioning manufacturer, trade name, nominal diameter, spool type, net weight, heat number, standards and CE mark.

PITTARC	SIAT S.p.A. 33013 Gemona del Friuli (UD) ITALY
CE 0036 06 ref. DoP PITTARC S3Mo-2014-04 EN 13479:2004 Use in metallic structures or in composite metal and concrete structures	PITTARC S3Mo Welding wire for carbon steels and fine-grained steels ISO 14171-A-S3Mo and AWS A5.23 EA4 *APPROVALS*: TUV, Nr.07172 DB-Zul.-Nr.52.044.09/01 Weight kg: XX — Heat N°: XXXXX/XX — Diameter: X,X mm — Spool type: X XXX

6. STANDARD CERTIFICATION

Documents according to EN 10204

7. APPROVALS: TÜV, DB.

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