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**TECHNICAL SPECIFICATION  
SUBMERGED ARC WELDING WIRE  
PITTARC S3Ni1Mo**

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**1. DESCRIPTION**

Submerged arc welding wire conforming standards ISO 26304-A-S3Ni1Mo and AWS A5.23 EF3 suitable to join Ni-Mo low alloy steels for construction, pressure vessels, pipes.

**2. PRODUCT CHEMICAL COMPOSITION (%)**

		%C	%Mn	%Si	%P	%S	%Cr	%Ni	%Mo	%Cu	%Al
Pittarc S3Ni1Mo	min	0.10	1.70	0.05	-	-	-	0.80	0.45	-	-
	max	0.15	1.80	0.25	0.020	0.020	0.20	1.00	0.65	0.30	0.02
ISO 26304-A-S3Ni1Mo	min	0.07	1.30	0.05	-	-	-	0.80	0.45	-	-
	max	0.15	1.80	0.35	0.020	0.020	0.20	1.20	0.65	0.30	0.02
AWS A5.23 EF3	min	0.10	1.50	-	-	-	-	0.70	0.40	-	-
	max	0.18	2.40	0.30	0.025	0.025	-	1.10	0.65	0.35	-

Note: The standard ISO 26304 require a total residual of other elements lower than 0,50%.

**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.

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	<b>PITTARC S3Ni1Mo</b>
0036 06 ref. DoP PITTARC S3Ni1Mo-2014-04 EN 13479:2004 Use in metallic structures or in composite metal and concrete structures	Welding wire for carbon steels and fine-grained steels ISO 26304-A-S3Ni1Mo and AWS A5.23 EF3
	APPROVALS: TUV Nr.07172
	Weight kg    Heat N°    Diameter    Spool type XX            XXXXX/XX    X,X mm    X XXX

**6. STANDARD CERTIFICATION**

Documents according to EN 10204

**7. APPROVALS: TÜV.**

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