

## SDA D3

**CATEGORY** SAW Arc Submerged

**TYPE** Solid wire for Submerged Arc Welding

**APPLICATIONS** Pipe work; pressure vessels; bridge; apparatus, and steam turbine construction. Suitable for unalloyed and fine grain steels up to 460N/mm<sup>2</sup> Yield strength.

**CLASSIFICATION**

AWS	A 5.17: ~EH 12K A 5.23: F7A5-EH12.
EN ISO	14171-A: S3Si
DIN: W.Nr.	1.0496

**SUITABLE FOR** X42, X 60, X65, X70, S355, S420, S460

**APPROVALS** TÜV, DB, Lloyds (5Y46), ABS (5Y46), DNV (5Y46).

**WELDING POSITIONS:**



**WELD METAL ANALYSIS % (WITH ST 55)**

C	Mn	Si	P	S
0.1	1.5-1.6	0.3	< 0.025	< 0.025

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
				-20°C	-40°C	-60°C	
AW	> 460	> 570	> 20		> 100	> 80	
PWHT	> 460	> 500	> 20		> 120	> 100	

AW: as welded , PWHT: 610°C / 1hr

**WELDING PARAMETERS / PACKING**

D (mm)	Welding Parameters		Packing		
	Voltage (V)	Current (A) DC+	spool / drum	kg / spool / drum	kg / pallet
2.0	26-29	300-400	K-415 / Drum	25 / 300	
2.4	27-30	350-450	K-415 / Drum	25 / 300	
3.2	27-30	425-525	K-415 / Drum	25 / 300	
4.0	27-30	475-575	K-415 / Drum	25 / 300	

**REDRYING TEMPERATURE** not required