

## Classifications

**EN ISO 26304-A**
**AWS A5.23 / SFA-5.23**

S 69 6 FB SZ3Ni2,5CrMo H5

F11A8-EG-F6 / F11P4-EG-F6

## Characteristics and typical fields of application

**Union S 3 NiMoCr – UV 418 TT** is a wire – flux combination for Submerged Arc Welding of high strength steel grades. Very good slag detachability also for narrow gap welding.

**UV 418 TT** is an agglomerated fluoride-basic flux with high basicity and neutral metallurgical behaviour. For more information regarding this sub-arc welding flux see our detailed data sheet.

## Base materials

Fine grained structural steels, especially for HT steels with yield strength up to 690 MPa.

## Typical analysis

wt.-%	C	Si	Mn	Cr	Ni	Mo
all-weld metal	0.08	0.15	1.60	0.32	2.00	0.58

## Mechanical properties of all-weld metal - typical values (min. values)

Condition	Yield strength	Tensile strength $R_m$	Elongation A ( $L_0=5d_0$ )	Impact energy ISO-V KV J			
	$R_{p0.2}$ MPa	MPa	%	-60°C	-40°C	-20°C	20°C
u, DC+	≥ 690	≥ 770	≥ 17	≥ 47	≥ 60	≥ 80	≥ 120

u untreated, as welded

## Operating data

Polarity	DC / AC	Dimension mm
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Redrying	300 – 350 °C, 2 hrs min.	

Preheating and interpass temperature as required by the base material: 150 – 180°C

Heat Input < 2.0 kJ/mm

## Approvals

TÜV (11585), CE ; (In progress : ABS, BV, DB, DNV GL, LR)