

OE-SD3 1Ni 1/2Mo is a coppered SAW wire for welding unalloyed and low alloyed steel grades. The wire has been especially designed to be used in multi run applications with OP 121TT for high strength properties (MSYS 550 – 550 MPa) combined with best charpy toughness down to -60°C and good CTOD values at -10°C. Applications in high strength applications in as welded as well as in PWHT condition. For thick weldments that need very long PWHT-duration OP 41TTW is the best choice to limit the loss in strength properties.

Classification	
EN ISO	26304-A-S3Ni1Mo
AWS	A5.23: EF3/EG

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Ni	Mo
0.12	1.7	0.2	≤ 0.015	≤ 0.015	0.95	0.5

Packaging data

Packaging Type	B450
Diam(mm) / weight(kg)	25
2.4	●
3.2	●
4.0	●