

OE-SD3 is a coppered SAW wire for welding unalloyed steel grades. The wire is especially designed to be used in multi-run applications with OP 121TT to obtain high chapy toughness values even down to -60°C.

When OE-SD3 is combined with OP 41TTW the weld metal will keep its strength properties even after a very long PWHT (e.g. 16 hrs at 620 °C).

### Classification

EN ISO 14171-A-S3Si

AWS A5.17: EH 12K

### Chemical analysis (Typical values in %)

C	Mn	Si	P	S
0.1	1.7	0.3	≤0.015	≤0.015

### Packaging data

Packaging Type	B450	B570	DRUM
Diam(mm) / weight(kg)	25	90	300
2.0	●		
2.4	●		●
3.2	●		●
4.0	●	●	●