**SAW (submerged arc welding) wires for high strength structural steels**

**UP-101 NiCrMo 2,5 (S3NiCrMo2,5)**

<table>
<thead>
<tr>
<th>Classification DIN EN ISO</th>
<th>Classification AWS</th>
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</thead>
<tbody>
<tr>
<td>26304-A S3Ni2,5CrMo</td>
<td>A5.23 ~EM4</td>
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**Approvals**

<table>
<thead>
<tr>
<th>TÜV 03275, CE</th>
<th>Material No.</th>
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**Characteristics and application**

Submerged arc welding wire for high strength quenched and tempered steels. Applications will be found in the offshore industry, shipbuilding, pressure vessels, earthmoving equipment, cranes and general structural fabrication.

**Base materials**

For high strength low alloy steels with yield strength up to 690MPa (100ksi).
S500Q-S690Q, S500QL-S690QL, P500Q-P690Q, P500QL1-P690QL1
ASTM: A514, A517. HY80, HY100, Q1(N)

**Typical analysis in %**

<table>
<thead>
<tr>
<th>C</th>
<th>Si</th>
<th>Mn</th>
<th>Cr</th>
<th>Ni</th>
<th>Mo</th>
</tr>
</thead>
<tbody>
<tr>
<td>0,11</td>
<td>0,17</td>
<td>1,40</td>
<td>0,70</td>
<td>2,40</td>
<td>0,55</td>
</tr>
</tbody>
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**Typical heat treatment**

Welding procedure (including preheat temperature, interpass temperature and PWHT) will be dependent on the base material being welded, including its thickness, and any applicable design codes.