



**DATA SHEET
DS 257
Rev. 05 dd 12/09/2013
INESUB EA3**

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CLASSIFICATION

AWS SPECIFICATIONS	EN SPECIFICATIONS
AWS A 5.23: EA3	EN ISO 14171-A: S4Mo
AWS A 5.23M: EA3	
ASME SFA 5.23: EA3	
ASME SFA 5.23M: EA3	

APPROVALS

ALLOY TYPE

Solid wire for submerged arc welding with 0.5% Mo content for welding high strength steels.

APPLICATIONS

Copper-coated solid wire for submerged arc welding with 2% Mn and 0,5% Mo content designed for welding low-alloy steels with high tensile strength and creep-resistant steels, keeping high yield values even after heat treatment. Suitable for pipelines and pressure vessels with operating temperatures of about 500°C. Good impact strength at low temperatures. To be used with fluxes, such as INEFLEX MP.

MATERIALS TO BE WELDED

ASTM		EN		Others
AISI 4130		10028-2 P295 G H	10113-2 S420	
A 487 Gr 2A		10028-2 P355 G H	10113-3 S275	
A 487 Gr 2B		10028-2 16Mo2	10113-3 S355	
A 487 Gr 2C		10222-2 17Mo3	10113-3 S420	
		10222-2 14Mo6		
		10113-2 S275		
		10113-2 S355		

WELDING GUIDELINES

Preheat and interpass temperature 150°C. PWHT at 620°C for an hour.

TECHNICAL INFORMATION

Welding positions: flat and flat-frontal





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WELDING PARAMETERS

Current	DC + Reverse polarity, AC					
	2.0	2.4	3.2	4.0		
Diameter (mm)	2.0	2.4	3.2	4.0		
Intensity (A)	300 ÷ 400	350 ÷ 450	430 ÷ 530	480 ÷ 580		
Volts (V)	26 ÷ 29	27 ÷ 30	27 ÷ 30	27 ÷ 30		

TYPICAL CHEMICAL COMPOSITION OF WIRE

C %	Mn %	Si %	S %	P %	Cr %	Ni %	Mo %	Cu %	
0.10	2.00	0.15	0.010	0.010	-	-	0.55	0.15	

NOTE: refer to the results obtained with the relevant flux for the mechanical characteristics of the deposited metal.

PRODUCTS AVAILABLE

Process	Product	Classification AWS	Classification EN
MIG/MAG Solid wire	INEFIL G2MO	AWS A 5.28: ER70S-A1	EN 21952-A: G MoSi EN 14341-A: G2Mo
	INEFIL D2	AWS A 5.28: ER80S-D2 AWS A 5.28: ER90S-D2	EN 14341-A: G 4Mo
TIG Rods	INETIG G2MO	AWS A 5.28: ER70S-A1	EN 21952-A: W MoSi EN 636-A: W2Mo
	INETIG D2	AWS A 5.28: ER80S-D2 AWS A 5.28: ER90S-D2	EN 636-B: W4M31
SAW Submerged arc	INESUB S2MO	AWS A 5.23: EA2	EN 14171-A: S2Mo
FCAW Cored wire	INETUB M81TG-A1	AWS A 5.28: E80C-G	EN 17632-A: T Mo
	INETUB B81T5-A1	AWS A 5.29: E81T5-A1	EN 17634-A: T Mo
SMAW Electrodes	INE A1	AWS A 5.5: E7018-A1	EN 3580-A: E Mo