



# CEWELD SACW 890

TYPE	High- basicity flux-cored wire for submerged-arc welding																
ANWENDUNGEN	Crane, automobile, equipment and steel construction, pipeline, foundries.																
EIGENSCHAFTEN	Crack resistant weld metal conditioned by the high-basicity slag in combination with very low hydrogen content. Well suited for the economic joining of high strength steels and cryogenic fine grain structural steels with $R_{p0,2} > 890$ MPa (129 ksi). To reach the optimal mechanical properties, the energy absorbed per unit length of weld 15 kJ/cm should not be exceeded. The working temperature should be between 100°C (212 °F) and 150°C (302 °F) . As welding flux FL 155 should be used because of its high basicity and low hydrogen content.																
KLASSIFIKATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.23: F12AB-ECG</td> </tr> <tr> <td>EN ISO</td> <td>26304-A: S 89 FB T3Ni2,5Cr1Mo</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>2</td> </tr> </table>	AWS	A 5.23: F12AB-ECG	EN ISO	26304-A: S 89 FB T3Ni2,5Cr1Mo	F-nr	6	FM	2								
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GEEIGNET FÜR	<p><b>Reh &lt; 890 Mpa Iso 15608: 3.2 (Reh &gt; 690 MPa)</b>            1.8796, 1.8925, 1.8940, 1.8983, 1.8797, 1.8933, 1.8934, 1.8941, 1.8997            S690Q-S890Q, S690QL-S890QL, S720MC            ASTM A 709 Gr. 100 Type B, E, F, H, Q, HPS 100W            N-A-XTRA M 700, PAS 700, alform 700 M, alform 900 x-treme, alform® 890 x-treme, Strenx 700-890, DILLIMAX 700-890</p>																
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SCHWEISSPOSITIONEN																	
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> </tr> </thead> <tbody> <tr> <td>0.08</td> <td>0.4</td> <td>1.6</td> <td>0.015</td> <td>0.015</td> <td>1</td> <td>2.4</td> <td>0.6</td> </tr> </tbody> </table>	C	Si	Mn	P	S	Cr	Ni	Mo	0.08	0.4	1.6	0.015	0.015	1	2.4	0.6
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