



# CEWELD SACW 500 QT

**TYPE** High basic seamless fluxcored wire for submerged arc welding (SAW)

**ANWENDUNGEN** Offshore, Shipbuilding, pressure vessels, pipe work, cable drums.

**EIGENSCHAFTEN** Micro alloyed submerged arc welding wire for offshore requirements upto S460 steels that have to fulfill impact requirements down to -60 degrees Celsius and parts that have to be soft annealed above 900 degrees Celsius. Suitable for use with FL 155 agglomerated flux or with FL CS155 fused flux.

**KLASSIFIKATION**

AWS	A 5.23: F7A8-ECG
EN ISO	14171-A: S 46 6 FB T3Ni1
F-nr	6
FM	1

**GEEIGNET FÜR**

Materials	DIN	EN	ASTM
shipbuilding	A, B, D, E, AH 32 - EH 36	same	Typical
Unalloyed steels	St 33, St 37-2 - St 52-3	S185 - S355-S460	A 255 / A333
boiler steels	H I, H III, 17Mn4, 19Mn5	P235GH, P355GH	A 516 / A 350
pipe steels	St 35.8, St 45.8	P235T1/T2, P460NL2	A 612 / A 707
-	StE 210.7 TM, StE 480.7 TM	L210 - L480MB	-
Fine grain steels	StE 255 to StE 460	S255 - S500 (NL1,2)	-
API-standard	X 42, X65, X 70	X 42, X65, X 70	-

**ZULASSUNGEN** CE

**SCHWEISSPOSITIONEN**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

C	Si	Mn	P	S	Ni
0.08	0.3	1.5	0.02	0.02	0.9

**MECHANISCHE GÜTEWERTE**

Heat Treatment	R <sub>p0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
				-40°C	-60°C	
As Welded	520	600	25	100	80	HRc
620°C±15°C 1h	495	560	30	110	80	HRc

**RÜCKTROCKNUNG** Not required

**GAS ACC. EN ISO 14175**