



# CEWELD SACW 460

|               |                                                                                                                                                                                                                                                                                                                                                                                                                              |
|---------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| TYPE          | Highly basic flux cored wire for submerged arc welding                                                                                                                                                                                                                                                                                                                                                                       |
| TOEPASSINGEN  | Earthmoving equipment, offshore, drilling platforms, lifting, vessel building, transport, etc.                                                                                                                                                                                                                                                                                                                               |
| EIGENSCHAPPEN | Remarkable crack resistant weld metal in combination with very low hydrogen content. Therefore, suitable for the economic processing of fine grained structural steels up to 460 MPa yield strength. Excellent welding properties in combination with FL 155 high basic flux even in narrow gaps. Excellent wetting properties compare to solid wires that results in a bigger parameter range and improved deposition rate. |

|               |        |                                    |
|---------------|--------|------------------------------------|
| CLASSIFICATIE | AWS    | A 5.17: F8A4-EC1, A 5.23: F8A4-ECG |
|               | EN ISO | 14171-A: S 46 4 FB T3              |
|               | F-nr   | 6                                  |
|               | FM     | 1                                  |

|               |                   |                            |                    |               |
|---------------|-------------------|----------------------------|--------------------|---------------|
| GESCHIKT VOOR | <b>Materials</b>  | <b>DIN</b>                 | <b>EN</b>          | <b>ASTM</b>   |
|               | shipbuilding      | A, B, D, E, AH 32 - EH 36  | same               | Typical       |
|               | Unalloyed steels  | St 33, St 37-2 - St 52-3   | S185 - S355        | A 258 / A 516 |
|               | boiler steels     | H I, H III, 17Mn4, 19Mn5   | P235GH, P355GH     | A 662 / A 387 |
|               | pipe steels       | St 35.8, St 45.8           | P235T1/T2, P460NL2 | A 738 / A 612 |
|               | -                 | StE 210.7 TM, StE 445.7 TM | L210 - L445MB      | A 299         |
|               | Fine grain steels | StE 255 to StE 460         | S235 - S460QL1     | -             |
|               | API-standard      | X 42, X65, X 70            | X 42, X65, X 70    | -             |

|               |    |
|---------------|----|
| GOEDKEURINGEN | CE |
|---------------|----|

|             |                                                                                                                                                                                                                                                             |
|-------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| LASPOSITIES |    |
|-------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|

|                                             |      |     |     |       |       |
|---------------------------------------------|------|-----|-----|-------|-------|
| TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%) | C    | Si  | Mn  | P     | S     |
|                                             | 0.05 | 0.3 | 1.5 | 0.015 | 0.015 |

|                     |                |                         |                      |                    |                         |       |          |
|---------------------|----------------|-------------------------|----------------------|--------------------|-------------------------|-------|----------|
| MECHANISCHE WAARDEN | 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      | 549                     | 630                  | 29                 | 110                     | 80    | HRc      |

|           |              |
|-----------|--------------|
| HERDROGEN | Not required |
|-----------|--------------|

GAS ACC. EN ISO 14175



# CEWELD SACW 460

## SACW 460 2,4MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| K-415     | 25      | 8720663424037 |

## SACW 460 3,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| K-415     | 25      | 8720663424044 |

## SACW 460 4,0MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Drum      | 300     | 8720663424068 |
| K-415     | 25      | 8720663424051 |