



CEWELD SACW 550

TYPE High- basicity flux-cored wire for submerged-arc welding

APPLICATIONS Crane, offshore equipment, boiler, pipeline and apparatus construction, foundries etc.

PROPERTIES Extremely crack resistant weld metal conditioned by the high-basicity slag in combination with very low hydrogen content. Well suited for the economic joining of fine grain structural steels with yield strength of Rp0,2 550 MPa (80 ksi). As welding flux we recommend our type FL 155, classification S A FB 1 55 AC H5.

CLASSIFICATION

AWS	A 5.23: F9A8-ECF1-F1
EN ISO	26304-A: S 55 6 FB T3Ni1Mo
F-nr	6
FM	2

SUITABLE FOR

Materials:	EN	ASTM
fine grain structural steels	S315(NL1/2) - S550(Q/QL/QL1)	A 516 / A 255
High grade structural steels	15NiCuMoNb5 / WB 36	A 333 / A 350
-	20MnMoNi4-5	A 612 / A 707
-	11NiMoV53	-
-	17MnMoV6-4	-
pipe steels	P355T1/T2 - P460NL2, L360 - L550MB	-
steels to API-standard	X42, X65, X70, X80	-

W.Nr: 1.6311, 1.6341, 1.5403, 1.0562, 1.8924, NAXTRA 56, NAXTRA 63

APPROVALS CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S	Ni	Mo
	0.07	0.4	1.4	0.015	0.015	1.4	0.5

MECHANICAL PROPERTIES	Heat Treatment	Rp0,2 (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
					-40°C	-60°C	
	As Welded	558	650	27	165	100	HRC

REDRYING Not required

GAS ACC. EN ISO 14175