



CEWELD SACW 500 QT

TYPE	High basic seamless fluxcored wire for submerged arc welding (SAW)		
APPLICATIONS	Offshore, Shipbuilding, pressure vessels, pipe work, cable drums.		
PROPRIÉTÉS	Micro alloyed submerged arc welding wire for offshore requirements upto S460 steels that have to fullfill 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.		
CLASSIFICATION	AWS	A 5.23: F7A8-ECG	
	EN ISO	14171-A: S 46 6 FB T3Ni1	
	F-nr	6	
	FM	1	

CONVIENT POUR	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	-

AGRÉMENTS CE

POSITIONS DE SOUDAGE			
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ANALYSE CHIMIQUE TYPIQUE DU MÉTAL DE SOUDURE (%)	C	Si	Mn	P	S	Ni
	0.08	0.3	1.5	0.02	0.02	0.9

PROPRIÉTÉS MÉCANIQUES	Heat Treatment	R _{p0.2} (MPa)	R _m (MPa)	A5 (%)	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

ETUVAGE Not required

GAS ACC. EN ISO 14175