CEWELD SACW 890

certilas® THE FILLER METAL SPECIALIST

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 Rp0,2 > 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

AWS	A 5.23: F12AB-ECG
EN ISO	26304-A: S 89 FB T3Ni2,5Cr1Mo
F-nr	6
FM	2

GEEIGNET FÜR

Reh < 890 Mpa Iso 15608: 3.2 (Reh > 690 MPa)
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

ZULASSUNGEN: CE

SCHWEISSPOSITIONEN

TYPISCHE CHEMISCHE ANALYSE DES FÜLLMETALLS (%)

C	Si	Mn	P	S	Cr	Ni	Mo
0.08	0.4	1.6	0.015	0.015	1	2.4	0.6

MECHANISCHE GÜTEWERTE

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V -40°C	Hardness
As Welded	900	960	16	55	HRc

RÜCKTROCKNUNG: Not required

GAS ACC. EN ISO 14175