



CEWELD SACW 500 QT

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

APPLICATIONS Offshore, Shipbuilding, pressure vessels, pipe work, cable drums.

PROPERTIES 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

SUITABLE FOR

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	-

APPROVALS CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

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

MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	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

REDRYING Not required

GAS ACC. EN ISO 14175