



# CEWELD SACW 460 1W

**TYPE** Highly basic flux cored wire for submerged arc welding

**APPLICATIONS** Especially for applications in shipbuilding and pipe production.

**PROPERTIES** SACW460-1W is a cored wire with micro-alloy elements, which enables welding of one side with one layer and layer counter layer with very good quality values. Also available in the variants 2-3W in combination with solid wire

**CLASSIFICATION** AWS A 5.23: F8A6-ECG  
EN ISO 14171-A: S 46 4 FB T3

**SUITABLE FOR** S355ML-S460ML, S460Q, S460QL, P355GH, P355N-P460N, P355NL2-P460NL2, P355M-P460M, P355ML2-P460ML2, P355Q-P460Q Shipbuilding grades A-E, AH40-FH40

**APPROVALS**

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

C	Si	Mn	P	S
0.03	0.6	1.8	0.02	0.02

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
				-20°C	-40°C	
As Welded	470	560	22	100	80	HRc

**REDRYING** Not required

**GAS ACC.** EN ISO 14175