



# CEWELD SACW 550

|               |                                                                                                                                                                                                                                                                                                                               |
|---------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| TYPE          | High- basicity flux-cored wire for submerged-arc welding                                                                                                                                                                                                                                                                      |
| TOEPASSINGEN  | Crane, offshore equipment, boiler, pipeline and apparatus construction, foundries etc.                                                                                                                                                                                                                                        |
| EIGENSCHAPPEN | 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. |

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

|               |                              |                                    |               |
|---------------|------------------------------|------------------------------------|---------------|
| GESCHIKT VOOR | <b>Materials:</b>            | <b>EN</b>                          | <b>ASTM</b>   |
|               | 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

|               |    |
|---------------|----|
| GOEDKEURINGEN | CE |
|---------------|----|

|             |                                                                                                                                                                                                                                                             |
|-------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| LASPOSITIES |    |
|-------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|

|                                             |      |     |     |       |       |     |     |
|---------------------------------------------|------|-----|-----|-------|-------|-----|-----|
| 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 |

|                     |                |                         |                      |                    |                         |       |          |
|---------------------|----------------|-------------------------|----------------------|--------------------|-------------------------|-------|----------|
| MECHANISCHE WAARDEN | Heat Treatment | R <sub>p0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |       | Hardness |
|                     |                |                         |                      |                    | -40°C                   | -60°C |          |
|                     | As Welded      | 558                     | 650                  | 27                 | 165                     | 100   | HRC      |

|           |              |
|-----------|--------------|
| HERDROGEN | Not required |
|-----------|--------------|

GAS ACC. EN ISO 14175