

CEWELD SACW 460

TYPE Highly basic flux cored wire for submerged arc welding

APPLICATIONS Earthmoving equipment, offshore, drilling platforms, lifting, vessel building, transport, etc.

PROPRIÉTÉS Remarkable crack resistant weld metal in combination with very low hydrogen content. Therefore, suitable for the economic processing of fine grained structural steels up to 460 MPa yield strength. Excellent welding properties in combination with FL 155 high basic flux even in narrow gabs. Excellent wetting properties compare to solid wires that results in a bigger parameter range and improved deposition rate.

CLASSIFICATION

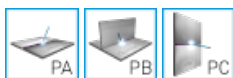
AWS	A 5.17: F8A4-EC1, A 5.23: F8A4-ECG
EN ISO	14171-A: S 46 4 FB T3
F-nr	6
FM	1

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	A 258 / A 516
boiler steels	H I, H III, 17Mn4, 19Mn5	P235GH, P355GH	A 662 / A 387
pipe steels	St 35.8, St 45.8	P235T1/T2, P460NL2	A 738 / A 612
-	StE 210.7 TM, StE 445.7 TM	L210 - L445MB	A 299
Fine grain steels	StE 255 to StE 460	S235 - S460QL1	-
API-standard	X 42, X65, X 70	X 42, X65, X 70	-

AGRÉMENTS CE

POSITIONS DE SOUDAGE



**ANALYSE CHIMIQUE
TYPIQUE DU MÉTAL DE
SOUDURE (%)**

C	Si	Mn	P	S
0.05	0.3	1.5	0.015	0.015

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				-40°C	-60°C	
As Welded	549	630	29	110	80	HRc

ETUVAGE Not required

GAS ACC. EN ISO 14175



CEWELD SACW 460

SACW 460 2,4MM

Packaging	KG/unit	EanCode
K-415	25	8720663424037

SACW 460 3,2MM

Packaging	KG/unit	EanCode
K-415	25	8720663424044

SACW 460 4,0MM

Packaging	KG/unit	EanCode
Drum	300	8720663424068
K-415	25	8720663424051