



# CEWELD SACW 500 QT

<b>TYPE</b>	High basic seamless fluxcored wire for submerged arc welding (SAW)	
<b>APPLICATIONS</b>	Offshore, Shipbuilding, pressure vessels, pipe work, cable drums.	
<b>PROPERTIES</b>	Micro alloyed submerged arc welding wire for offshore requirements upto S460 steels that have to fulfill 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.	
<b>CLASSIFICATION</b>	AWS	A 5.23: F7A8-ECG
	EN ISO	14171-A: S 46 6 FB T3Ni1
	F-nr	6
	FM	1

<b>SUITABLE FOR</b>	<b>Materials</b>	<b>DIN</b>	<b>EN</b>	<b>ASTM</b>
	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

**ALL WELD MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)	Impact Energy (J) ISO-V	
				-40°C	-60°C
As Welded /	520	600	25	100	80
620°C±15°C /1h	495	560	30	110	80

**REDRYING TEMPERATURE** Not required

**GAS ACCORDING EN 14175**