



CEWELD SACW 550

TYPE	High- basicity flux-cored wire for submerged-arc welding		
ANWENDUNGEN	Crane, offshore equipment, boiler, pipeline and apparatus construction, foundries etc.		
EIGENSCHAFTEN	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.		
KLASSIFIKATION	AWS	A 5.23: F9A8-ECF1-F1	
	EN ISO	26304-A: S 55 6 FB T3Ni1Mo	
	F-nr	6	
	FM	2	

GEEIGNET FÜR	Materials:	EN	ASTM
	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

ZULASSUNGEN CE

SCHWEISSPOSITIONEN



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 GÜTEWERTE

Heat Treatment	Rp0,2 (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				-40°C	-60°C	
As Welded	558	650	27	165	100	HRC

RÜCKTROCKNUNG Not required

GAS ACC. EN ISO 14175