CEWELD SACW 500 QT

certilas® THE FILLER METAL SPECIALIST

TYPE	High basic seamless fluxcored wire for submerged arc welding (SAW)
ANWENDUNGEN	Offshore, Shipbuilding, pressure vessels, pipe work, cable drums.
EIGENSCHAFTEN	Micro alloyed submerged arc welding wire for offshore requirements upto S460 steels that have to fullfill 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.

KLASSIFIKATION

AWS	A 5.23: F7A8-ECG
EN ISO	14171-A: S 46 6 FB T3Ni1
F-nr	6
FM	1

GEEIGNET FÜR

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-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	

ZULASSUNGEN: CE

SCHWEISSPOSITIONEN

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Ni
0.08	0.3	1.5	0.02	0.02	0.9

MECHANISCHE GÜTEWERTE

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				-40°C	-60°C	
As Welded	520	600	25	100	80	HRc
620°C±15°C 1h	495	560	30	110	80	HRc

RÜCKTROCKNUNG: Not required

GAS ACC. EN ISO 14175