



CEWELD SACW 690

| TYPE | High- basicity flux-cored wire for submerged-arc welding. | | | | | | | | | | | | | | | | |
|---|---|----------------|-------------------------|----------------------|--------------------------------|-------------------------|--------------------|----------|-------------------------|-------|-----------|-----|-------|-------|-----|-----|------|
| APPLICATIONS | Crane-, rig, plant-, craft-, lifting and steel construction, pipe work, foundries | | | | | | | | | | | | | | | | |
| PROPRIÉTÉS | Remarkable crack resistant weld metal in combination with very low hydrogen content. Therefore, suitable for the economic processing of high-strength and low temperature fine grained structural steels. 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. To obtain optimum mechanical properties the heat input should be kept below 15 kJ/cm and interpass temperature between 100 and 150°C. | | | | | | | | | | | | | | | | |
| CLASSIFICATION | <table border="0"> <tr> <td>AWS</td> <td>A 5.23: F11A8-ECF5-F5</td> </tr> <tr> <td>EN ISO</td> <td>26304-A: S 69 6 FB T3Ni2,5CrMo</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>2</td> </tr> </table> | AWS | A 5.23: F11A8-ECF5-F5 | EN ISO | 26304-A: S 69 6 FB T3Ni2,5CrMo | F-nr | 6 | FM | 2 | | | | | | | | |
| AWS | A 5.23: F11A8-ECF5-F5 | | | | | | | | | | | | | | | | |
| EN ISO | 26304-A: S 69 6 FB T3Ni2,5CrMo | | | | | | | | | | | | | | | | |
| F-nr | 6 | | | | | | | | | | | | | | | | |
| FM | 2 | | | | | | | | | | | | | | | | |
| CONVIENT POUR | <p>Reh < 690 MPa Iso 15608: 2.2 u 3.2 (460 < Reh ≤ 690(700) MPa) 1.8914, 1.8927, 1.8931, 1.8928, 1.8974, 1.7147, 1.7149, 1.8734 S620Q, S620QL, S690Q, S690QL, S620QL1-S690QL1, 20MnCr65, 28CrMn4-3 L480 - L550, X65, X80, X90, X100 ASTM A 514 Gr. F, H, Q; A 709 Gr. 100 Type B, E, F, H, Q; A 709 Gr. HPS 100W Weldox 700, Dillimax 690, Hardox, Naxtra 63, Naxtra 70, Optim 700 mc plus, Weldox 500, Hardox, Domex 460 MC, Domex 500 MC, Domex 550 MC, Domex 600 MC, Domex 650 MC, Domex 700 MC, Hardox 400, Strenx 700; XAR 400, Dillidur 400, Oceanfit 100, Oceanfit 690, alform plate 620 M, 700 M, aldur 620 Q, 620 QL, 620 QL1, aldur 700 Q, 700 QL, 700 QL1, Salzgitter S700MC, Ympress Steel E690 TM, S700MC, Armstrong Ultra 650MC, 650 MCt, 700 MC.....</p> | | | | | | | | | | | | | | | | |
| AGRÉMENTS | CE, TÜV: 12709 | | | | | | | | | | | | | | | | |
| POSITIONS DE SOUDAGE | | | | | | | | | | | | | | | | | |
| TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%) | <table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> </tr> </thead> <tbody> <tr> <td>0.08</td> <td>0.4</td> <td>1.6</td> <td>0.015</td> <td>0.015</td> <td>0.5</td> <td>2.3</td> <td>0.45</td> </tr> </tbody> </table> | C | Si | Mn | P | S | Cr | Ni | Mo | 0.08 | 0.4 | 1.6 | 0.015 | 0.015 | 0.5 | 2.3 | 0.45 |
| C | Si | Mn | P | S | Cr | Ni | Mo | | | | | | | | | | |
| 0.08 | 0.4 | 1.6 | 0.015 | 0.015 | 0.5 | 2.3 | 0.45 | | | | | | | | | | |
| PROPRIÉTÉS MÉCANIQUES | <table border="1"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R_{P0,2} (MPa)</th> <th rowspan="2">R_m (MPa)</th> <th rowspan="2">A₅ (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th>-40°C</th> <th>-60°C</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>731</td> <td>829</td> <td>18</td> <td>120</td> <td>95</td> <td>HRC</td> </tr> </tbody> </table> | Heat Treatment | R _{P0,2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | | Hardness | -40°C | -60°C | As Welded | 731 | 829 | 18 | 120 | 95 | HRC |
| Heat Treatment | R _{P0,2} (MPa) | | | | | R _m (MPa) | A ₅ (%) | | Impact Energy (J) ISO-V | | Hardness | | | | | | |
| | | -40°C | -60°C | | | | | | | | | | | | | | |
| As Welded | 731 | 829 | 18 | 120 | 95 | HRC | | | | | | | | | | | |
| ETUVAGE | Not required | | | | | | | | | | | | | | | | |
| GAS ACC. EN ISO 14175 | | | | | | | | | | | | | | | | | |



CEWELD SACW 690

SACW 690 2,4MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| K-415 | 25 | 8720663424099 |

SACW 690 4,0MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| K-415 | 25 | 8720663424105 |