



CEWELD SACW 890

TYPE	High- basicity flux-cored wire for submerged-arc welding																
TOEPASSINGEN	Crane, automobile, equipment and steel construction, pipeline, foundries.																
EIGENSCHAPPEN	Crack resistant weld metal conditioned by the high-basicity slag in combination with very low hydrogen content. Well suited for the economic joining of high strength steels and cryogenic fine grain structural steels with $R_{p0.2} > 890 \text{ MPa}$ (129 ksi). To reach the optimal mechanical properties, the energy absorbed per unit length of weld 15 kJ/cm should not be exceeded. The working temperature should be between 100°C (212 °F) and 150°C (302 °F). As welding flux FL 155 should be used because of its high basicity and low hydrogen content.																
CLASSIFICATIE	AWS A 5.23: F12AB-ECG EN ISO 26304-A: S 89 FB T3Ni2,5Cr1Mo F-nr 6 FM 2																
GESCHIKT VOOR	Reh < 890 Mpa Iso 15608: 3.2 (Reh > 690 Mpa) 1.8796, 1. 8925, 1.8940, 1.8983, 1.8797, 1.8933, 1.8934, 1.8941, 1.8997 S690Q-S890Q, S690QL-S890QL, S720MC ASTM A 709 Gr. 100 Type B, E, F, H, Q, HPS 100W N-A-XTRA M 700, PAS 700, alform 700 M, alform 900 x-treme, alform® 890 x-treme, Strenx 700-890, DILLIMAX 700-890																
GOEDKEURINGEN	CE																
LASPOSITIONS																	
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table><tr><td>C</td><td>Si</td><td>Mn</td><td>P</td><td>S</td><td>Cr</td><td>Ni</td><td>Mo</td></tr><tr><td>0.08</td><td>0.4</td><td>1.6</td><td>0.015</td><td>0.015</td><td>1</td><td>2.4</td><td>0.6</td></tr></table>	C	Si	Mn	P	S	Cr	Ni	Mo	0.08	0.4	1.6	0.015	0.015	1	2.4	0.6
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MECHANISCHE WAARDEN	<table><thead><tr><th rowspan="2">Heat Treatment</th><th rowspan="2">$R_{p0.2}$ (MPa)</th><th rowspan="2">Rm (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>55</th></tr></thead><tbody><tr><td>As Welded</td><td>900</td><td>960</td><td>16</td><td></td><td></td><td>HRc</td></tr></tbody></table>	Heat Treatment	$R_{p0.2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness	-40°C	55	As Welded	900	960	16			HRc
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HERDROGEN	Not required																

GAS ACC. EN ISO 14175