

## SACW 460

<b>CATEGORY</b>	SAW Arc Submerged
<b>TYPE</b>	Highly basic flux cored wire for submerged arc welding
<b>APPLICATIONS</b>	Earthmoving equipment, offshore, drilling platforms, lifting, vessel building, transport, etc.
<b>PROPERTIES</b>	Remarkable crack resistant weld metal in combination with very low hydrogen content. Therefore, suitable for the economic processing of fine grained structural steels up to 460 N/mm <sup>2</sup> yield strength. Excellent welding properties in combination with FL 155 high basic flux even in narrow gaps. Excellent wetting properties compare to solid wires that results in a bigger parameter range and improved deposition rate.

<b>CLASSIFICATION</b>	AWS	A 5.17: F8A4-EC-15.23: F8A4-EC-G 5.23: F8A4-EC-G
	EN ISO	14171-A: S 46 4 FB T3

SUITABLE FOR	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	A 258 / A 516
	boiler steels	H I, H III, 17Mn4, 19Mn5	P235GH, P355GH	A 662 / A 387
	pipe steels	St 35.8, St 45.8	P235T1/T2, P460NL2	A 738 / A 612
	-	StE 210.7 TM, StE 445.7 TM	L210 - L445MB	A 299
	Fine grain steels	StE 255 to StE 460	S235 - S460QL1	-
	API-standard	X 42, X65, X 70	X 42, X65, X 70	-

<b>APPROVALS</b>	CE approved
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<b>WELDING POSITIONS:</b>	
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<b>WELD METAL ANALYSIS %</b>	C	Mn	Si	P	S
	0.05	1.5	0.3	< 0.025	< 0.020

<b>MECHANICAL PROPERTIES (WITH FL 155)</b>	Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A5 (%)	Impact Energy (J) ISO-V	
	AW	> 460	540-640	> 25	-20°C	-40°C
					> 140	> 100

AW: as welded

<b>WELDING PARAMETERS / PACKING</b>	Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A) (DC+)	spooling type	kg / spool / drum	kg / pallet	
2,0	28-34	180-320	K-415 / Drum	25 / 300		
2,4	28-38	250-500	K-415 / Drum	25 / 300		
3,2	28-40	400-800	K-415 / Drum	25 / 300		
4,0	28-40	500-900	K-415 / Drum	25 / 300		

<b>REDRYING TEMPERATURE</b>	not required
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