

SACW 500

CATEGORY	SAW Arc Submerged						
TYPE	High basic seamless fluxcored wire for submerged arc welding (SAW)						
APPLICATIONS	Offshore, Shipbuilding, pressure vessels, pipe work, cable drums.						
PROPERTIES	Micro alloyed submerged arc welding wire for offshore requirements upto S460 steels that have to fulfill 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.						
CLASSIFICATION	AWS	A 5.23: F7A8-EC-G / 5.23: F7P8-EC-G 5.23: F7P8-EC-G					
	EN ISO	14171-A: S 46 6 FB T3Ni1					
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-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	-			
APPROVALS	CE approved						
WELDING POSITIONS:							
TYPICAL DEPOSIT WEIGHT %	C	Mn	Si	P	S	Ni	
	0.13	1.20	0.20	<0.012	<0.005	1.00	
TYPICAL MECHANICAL PROPERTIES (WITH FL 155)							
Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A5 (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				-20°C	-40°C	-60°C	
as welded	560	670	22		150	90	
soft annealed	450	550	28		180	140	
WELDING PARAMETERS / PACKING							
Welding Parameters			Packing				
D (mm)	Voltage (V)	Current (A)	spool type / drum	kg spool / drum	kg / pallet		
2,4	28-32	250-400	K-415 / drum	25 / 300			
3,2	28-32	300-500	K-415 / drum	25 / 300			
4,0	28-34	350-650	K-415 / drum	25 / 300			
REDRYING TEMPERATURE	not required						