

SACW 890

CATEGORY SAW Arc Submerged

TYPE High- basicity flux-cored wire for submerged-arc welding

APPLICATIONS Crane, automobile, equipment and steel construction, pipeline, foundries.

PROPERTIES 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 $R_{p0,2} > 890$ 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.

CLASSIFICATION

AWS	A 5.23: ~F12A8-ECG A 5.23M: ~F83A6-ECG
EN ISO	26304-A: S 89 4 FB T3Ni2,5Cr1Mo

SUITABLE FOR TM-pipe steels to StE 890 to S890QL1, X120 high-strength fine grain structural steels (low temp) to StE 960 (StE 1100 to 12 mm) to S960QL1 (S1100). ASTM: up to A 714, A 709, A 515, A 517

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS % (TYPICAL)

C	Mn	Si	Cr	Ni	Mo	P	S
0.08	1.6	0.4	1.0	2.2	0.5	0.015	0.015

MECHANICAL PROPERTIES

Heat Treatment	$R_{p0,2}$ (N/mm ²)	Rm (N/mm ²)	A5 (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
				-20°C	-40°C	-60°C	
AW	>890	940-1180	15		55	40	

AW: as welded

WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters		spool type	Packing	
	Voltage (V)	Current (A) DC+		kg / spool	kg / pallet
2,0			K-415	25	
2,4			K-415	25	

REDRYING TEMPERATURE Not required