

FL 155

CATEGORY	SAW Submerged arc		
TYPE	High basic SAW flux with very low hydrogen content		
APPLICATIONS	Drilling platforms, crane building, offshore fundamentals, jack ups, narrow gab welding, multi layer welding.		
PROPERTIES	Neutral high basic flux suitable for a weight range of wire combinations including multi layer welding in high demanding offshore applications because of its low hydrogen content.		
	Basicity according to Boniszewski:	~3.4	
	Grain size according DIN EN 760:	2 - 16	

CLASSIFICATION EN ISO 14174: SA FB 1 55 AC(D) H5

SUITABLE FOR S355, S420, S460, S690, P500, P550, X65, X70, X80, Weldox 700, Naxtra 70, Hardox 400, Dilimax, P91, P24

APPROVALS Lloyds, DNV, TUV.. in progress

WELDING POSITIONS:



FILLER METAL ANALYSIS % (TYPICAL VALUES)

SiO ₂ +TiO ₂	CaO + MgO	Al ₂ O ₃ + MnO	CaF ₂	S	P
15	40	20	25	<0.015	<0.015

MECHANICAL PROPERTIES

with Wire	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	
S35i*	>460	530-680	>20			>47	
SACW 690*	>690	770-940	>17		>80	>69	

* For as welded condition and PWHT 580°C / 2hr.

REDRYING TEMPERATURE 300-350°C / 1-2hr

PACKING 25 kg sealed metal buckets / 25 kg bags.