

SACW 460

CATEGORY SAW Submerged arc

TYPE Highly basic flux cored wire for submerged arc welding

APPLICATIONS Earthmoving equipment, offshore, drilling platforms, lifting, vessel building, transport, etc.

PROPERTIES 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/mm² yield strength. Excellent welding properties in combination with ST 55 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.

CLASSIFICATION

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	-

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Mn	Si	P	S
0.05	1.5	0.3	< 0.025	< 0.020

MECHANICAL PROPERTIES (WITH FL 155)

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V	
				-20°C	-40°C
AW	> 460	540-640	> 25	> 140	> 100

AW: as welded

WELDING PARAMETERS / PACKING

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	

REDRYING TEMPERATURE not required