CEWELD®

SACW 690

CATEGORY	SAW Submerged arc
TYPE	High- basicity flux-cored wire for submerged-arc welding.
APPLICATIONS	Crane-, rig, plant-, craft-, lifting and steel construction, pipe work, foundries
PROPERTIES	Remarkable crack resistant weld metal in combination with very low hydrogen content. Therefore, suitable for the economic processing of high-strength and low temperature fine grained structural steels. Excellent welding properties in combination with FL 155 high basic flux even in narrow gabs. Excellent wetting properties compare to solid wires that results in a bigger parameter range and improved deposition rate. To obtain optimum mechanical properties the heat input should be kept below 15 kJ/cm and interpass temperature between 100 and 150ºC.
CLASSIFICATION	AWS A 5.23: F11A8-ECF5-F5 A 5.23M: F76A6-ECF5-F5 EN ISO 26304-A: S 69 6 FB T3Ni2,5CrMo
SUITABLE FOR	StE 690.7 TM, L690M, A 715, StE 690 V, S690QL, A 709, A 515, A 517, EStE 690 VA, S690G1QL1, A 514, A 633, A 709 Naxtra 70, Weldox 700, Dilimax, Optim 700 mc plus, S620Ql1, S690QL1, S600MC, S700MC, Naxtra 63, Naxtra 70, TStE620, TStE690, Weldox 500, Hardox, L480 - L550, X65, X80, X90, X100, Hardox 400, XAR 400, Dilidur 400, 20MnCr65, 28CrMn43, Oceanfit 100, Ocenanfit 690
APPROVALS	LLoyds (5Y69), DNV (5Y69), TUV in progess, CE approved
WELDING POSITIONS:	

WELD DEPOSIT ANALYSIS WITH ST55 (WEIGHT %)

C	Mn	Si	Cr	Ni	Mo	P	S
0.08	1,6	0,4	0,5	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 -20°C	-40°C	-60°C	Hardness HRc / HV
AW	>690	770-900	>17		>80	>69	

AW: as welded

WELDING PARAMETERS PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A) DC+	spool 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