


SACW 890

CATEGORY	SAW Submerged arc																																
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 Rp0,2 > 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)	<table><tr><td>C</td><td>Mn</td><td>Si</td><td>Cr</td><td>Ni</td><td>Mo</td><td>P</td><td>S</td></tr><tr><td>0.08</td><td>1.6</td><td>0.4</td><td>1.0</td><td>2.2</td><td>0.5</td><td>0.015</td><td>0.015</td></tr></table>						C	Mn	Si	Cr	Ni	Mo	P	S	0.08	1.6	0.4	1.0	2.2	0.5	0.015	0.015											
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