

SACW 550

CATEGORY SAW Arc Submerged

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

APPLICATIONS Crane, offshore equipment, boiler, pipeline and apparatus construction, foundries etc.

PROPERTIES Extremely crack resistant weld metal conditioned by the high-basicity slag in combination with very low hydrogen content. Well suited for the economic joining of fine grain structural steels with yield strength of $R_{p0,2}$ 550 MPa (80 ksi). As welding flux we recommend our type **FL 155**, classification S A FB 1 55 AC H5.

CLASSIFICATION

AWS	A 5.23: F 9 A8 - EC - G
	A 5.23M: F62A6-ECF1-F1
EN ISO	26304-A: S 55 6 FB T3Ni1Mo

SUITABLE FOR	Materials:	EN	ASTM
	fine grain structural steels	S315(NL1/2) - S550(Q/QL/QL1)	A 516 / A 255
	High grade structural steels	15NiCuMoNb5 / WB 36	A 333 / A 350
	-	20MnMoNi4-5	A 612 / A 707
	-	11NiMoV53	-
	-	17MnMoV6-4	-
	pipe steels	P355T1/T2 - P460NL2, L360 - L550MB	-
	steels to API-standard	X42, X65, X70, X80	-
	W.Nr: 1.6311, 1.6341, 1.5403, 1.0562, 1.8924, NAXTRA 56, NAXTRA 63		

APPROVALS CE approved.

WELDING POSITIONS:



WELD METAL ANALYSIS % (TYPICAL)

C	Mn	Si	Cr	Ni	Mo	P	S
0.06	1.2	0,3	-	0.9	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	>550	640-670	18		80	60	
SR	>500	550-700	20		80	60	

AW: as welded SR: stress relief annealed 605 - 635°C (1121-1175°F) / 60 min.

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