


CATEGORY	SAW Arc Submerged					
TYPE	Copper coated solid wire					
APPLICATIONS	Typical applications are found in the oil refinery industry.					
PROPERTIES	Submerged arc welding (5% chromium wire) for high temperature creep resistant steels. Flux CEWELD® FL 880					
CLASSIFICATION	AWS	A 5.23: EB6				
	EN ISO	24598-A: S CrMo5				
	F-nr	6				
	FM	4				
	W.Nr.	1.7374				
SUITABLE FOR	X12CrMo5, GX12CrMo5 ASTM: A182/A336 Grade F5, A199/A213 Grade T5, A217 Grade C5, A234 Grade WP5, A335 Grade P5, A387 Grade 5					
APPROVALS	CE					
WELDING POSITIONS:						
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)						
C	Si	Mn	P	S	Cr	Mo
0.08	0.3	0.5	0.01	0.01	6	0.6
ALL WELD MECHANICAL PROPERTIES						
Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V RT		
720°C±15°C /1h	510	630	20	60		
WELDING PARAMETERS / PACKING						
D (MM)	WELDING PARAMETERS	WELDING PARAMETERS	WELDING PARAMETERS	PACKING		
		VOLTAGE (V)	CURRENT (A)	KG / SPOOL		
3,2				25		
4,0				25		
4,8				25		
REDRYING TEMPERATURE	Not required					
GAS ACCORDING EN 14175						