

CATEGORY SAW Arc Submerged

TYPE Highly basic flux cored wire for submerged arc welding

APPLICATIONS Especially for applications in shipbuilding and pipe production.

PROPERTIES SACW460-1W is a cored wire with micro-alloy elements, which enables welding of one side with one layer and layer counter layer with very good quality values. Also available in the variants 2-3W in combination with solid wir

CLASSIFICATION  
AWS A 5.23: F8A6-ECG  
EN ISO 14171-A: S 46 4 FB T3

SUITABLE FOR S355ML-S460ML, S460Q, S460QL, P355GH, P355N-P460N, P355NL2-P460NL2, P355M-P460M, P355ML2-P460ML2, P355Q-P460Q Shipbuilding grades A-E, AH40-FH40

APPROVALS No Approvals Found

WELDING POSITIONS:



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S
0.03	0.6	1.8	0.02	0.02

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R <sub>p0.2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)	Impact Energy (J) ISO-V	
				-20°C	-40°C
As Welded /	470	560	22	100	80

WELDING PARAMETERS / PACKING

REDRYING TEMPERATURE Not required

GAS ACCORDING EN 14175