



# CEWELD SACW 460 1W

|                                             |                                                                                                                                                                                                                                 |                                           |                      |                    |                         |       |          |
|---------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------|----------------------|--------------------|-------------------------|-------|----------|
| TYPE                                        | Highly basic flux cored wire for submerged arc welding                                                                                                                                                                          |                                           |                      |                    |                         |       |          |
| TOEPASSINGEN                                | Especially for applications in shipbuilding and pipe production.                                                                                                                                                                |                                           |                      |                    |                         |       |          |
| EIGENSCHAPPEN                               | 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 |                                           |                      |                    |                         |       |          |
| CLASSIFICATIE                               | AWS<br>EN ISO                                                                                                                                                                                                                   | A 5.23: F8A6-ECG<br>14171-A: S 46 4 FB T3 |                      |                    |                         |       |          |
| GESCHIKT VOOR                               | S355ML-S460ML, S460Q, S460QL, P355GH, P355N-P460N, P355NL2-P460NL2, P355M-P460M, P355ML2-P460ML2, P355Q-P460Q Shipbuilding grades A-E, AH40-FH40                                                                                |                                           |                      |                    |                         |       |          |
| GOEDKEURINGEN                               |                                                                                                                                                                                                                                 |                                           |                      |                    |                         |       |          |
| LASPOSITIES                                 | <div></div>                                                   |                                           |                      |                    |                         |       |          |
| TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%) | C                                                                                                                                                                                                                               | Si                                        | Mn                   | P                  | S                       |       |          |
|                                             | 0.03                                                                                                                                                                                                                            | 0.6                                       | 1.8                  | 0.02               | 0.02                    |       |          |
| MECHANISCHE WAARDEN                         | Heat Treatment                                                                                                                                                                                                                  | R <sub>P0,2</sub> (MPa)                   | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |       | Hardness |
|                                             | As Welded                                                                                                                                                                                                                       | 470                                       | 560                  | 22                 | -20°C                   | -40°C |          |
|                                             |                                                                                                                                                                                                                                 |                                           |                      |                    | 100                     | 80    | HRc      |
| HERDROGEN                                   | Not required                                                                                                                                                                                                                    |                                           |                      |                    |                         |       |          |
| GAS ACC. EN ISO 14175                       |                                                                                                                                                                                                                                 |                                           |                      |                    |                         |       |          |