



CEWELD SACW 460

TYPE	Highly basic flux cored wire for submerged arc welding		
APPLICATIONS	Earthmoving equipment, offshore, drilling platforms, lifting, vessel building, transport, etc.		
PROPERTIES	Remarkable crack resistant weld metal in combination with very low hydrogen content. Therefore, suitable for the economic processing of fine grained structural steels up to 460 MPa yield strength. Excellent welding properties in combination with FL 155 high basic flux even in narrow gabs. Excellent wetting properties compare to solid wires that results in a bigger parameter range and improved deposition rate.		
CLASSIFICATION	AWS	A 5.17: F8A4-EC1, A 5.23: F8A4-ECG	
	EN ISO	14171-A: S 46 4 FB T3	
	F-nr	6	
	FM	1	

SUITABLE FOR	Materials	DIN	EN	ASTM
	shipbuilding	A, B, D, E, AH 32 - EH 36	same	Typical
	Unalloyed steels	St 33, St 37-2 - St 52-3	S185 - S355	A 258 / A 516
	boiler steels	H I, H III, 17Mn4, 19Mn5	P235GH, P355GH	A 662 / A 387
	pipe steels	St 35.8, St 45.8	P235T1/T2, P460NL2	A 738 / A 612
	-	StE 210.7 TM, StE 445.7 TM	L210 - L445MB	A 299
	Fine grain steels	StE 255 to StE 460	S235 - S460QL1	-
	API-standard	X 42, X65, X 70	X 42, X65, X 70	-

APPROVALS CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S
0.05	0.3	1.5	0.015	0.015

MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				-40°C	-60°C	
As Welded	549	630	29	110	80	HRc

REDRYING Not required

GAS ACC. EN ISO 14175



CEWELD SACW 460

SACW 460 2,4MM

Packaging	KG/unit	EanCode
K-415	25	8720663424037

SACW 460 3,2MM

Packaging	KG/unit	EanCode
K-415	25	8720663424044

SACW 460 4,0MM

Packaging	KG/unit	EanCode
Drum	300	8720663424068
K-415	25	8720663424051