



CEWELD SACW 460 1W

TYPE Highly basic flux cored wire for submerged arc welding

ANWENDUNGEN Especially for applications in shipbuilding and pipe production.

EIGENSCHAFTEN 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 wire

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

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

ZULASSUNGEN

SCHWEISSPOSITIONEN



TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%)

C	Si	Mn	P	S
0.03	0.6	1.8	0.02	0.02

MECHANISCHE GÜTEWERTE

Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				-20°C	-40°C	
As Welded	470	560	22	100	80	HRc

RÜCKTROCKNUNG Not required

GAS ACC. EN ISO 14175