



CEWELD SACW 460 1W

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 wire

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

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S
0.03	0.6	1.8	0.02	0.02

MECHANICAL PROPERTIES

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

REDRYING Not required

GAS ACC. EN ISO 14175