CEWELD SACW 690

certilas® THE FILLER METAL SPECIALIST

TYPE	High- basicity flux-cored wire for submerged-arc welding.
ANWENDUNGEN	Crane-, rig, plant-, craft-, lifting and steel construction, pipe work, foundries
EIGENSCHAFTEN	Remarkable crack resistant weld metal in combination with very low hydrogen content. Therefore, suitable for the economic processing of high-strength and low temperature fine grained structural steels. 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. To obtain optimum mechanical properties the heat input should be kept below 15 kJ/cm and interpass temperature between 100 and 150°C.

KLASSIFIKATION

AWS	A 5.23: F11A8-ECF5-F5
EN ISO	26304-A: S 69 6 FB T3Ni2,5CrMo
F-nr	6
FM	2

GEEIGNET FÜR

Reh < 690 MPa Iso 15608: 2.2 u 3.2 (460 < Reh ≤ 690(700) MPa)
1.8914, 1.8927, 1.8931, 1.8928, 1.8974, 1.7147, 1.7149, 1.8734
S620Q, S620QL, S690Q, S690QL, S620QL1-S690QL1, 20MnCr65, 28CrMn4-3
L480 - L550, X65, X80, X90, X100
ASTM A 514 Gr. F, H, Q; A 709 Gr. 100 Type B, E, F, H, Q; A 709 Gr. HPS 100W
Weldox 700, Dillimax 690, Hardox, Naxtra 63, Naxtra 70, Optim 700 mc plus, Weldox 500, Hardox, Domex 460 MC, Domex 500 MC, Domex 550 MC, Domex 600 MC, Domex 650 MC, Domex 700 MC, Hardox 400,Strenx 700; XAR 400, Dillidur 400, Oceanfit 100, Oceanfit 690, alform plate 620 M, 700 M, aldur 620 Q, 620 QL, 620 QL1, aldur 700 Q, 700 QL, 700 QL1, Salzgitter S700MC, Ympress Steel E690 TM, S700MC, Amstrong Ultra 650MC, 650 MCt, 700 MC.....

ZULASSUNGEN: CE

SCHWEISSPOSITIONEN

TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%)

C	Si	Mn	P	S	Cr	Ni	Mo
0.08	0.4	1.6	0.015	0.015	0.5	2.3	0.45

MECHANISCHE GÜTEWERTE

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				-40°C	-60°C	
As Welded	731	829	18	120	95	HRc

RÜCKTROCKNUNG: Not required

GAS ACC. EN ISO 14175

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SACW 690 2,4MM

Packaging	KG/unit	EanCode
K-415	25	8720663424099

SACW 690 4,0MM

Packaging	KG/unit	EanCode
K-415	25	8720663424105