
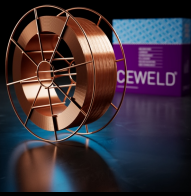




CEWELD AA B460

| TYPE | High-basic seamless flux-cored wire for CO2 and M21 | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|--|----------------|-------------------------|----------------------|----------------------------|-------------------------|--------------------|-------------------------|----------|-------|----------|-------|-----------|-----|-----|----|-----|----|----|-----|-----------------|-----|-----|----|-----|----|----|-----|
| ANWENDUNGEN | Shipbuilding, bridge construction, steel construction, mechanical engineering, pressure vessels and boiler constructions, foundries. | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| EIGENSCHAFTEN | Absolute crack resistant weld metal conditioned by the high-basic slag combined with ultra low hydrogen content (HD< 3 ml/100g). High mechanical properties also for single-sided welding on ceramics. X-ray-proof seams with low spatter loss. Suitable for high-carbon steels and welding critical mixed combinations. Metallurgical ideal filler metal for repair and production welding as well as for buffer layers. | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| KLASSIFIKATION | <table border="0"> <tr> <td>AWS</td> <td>A 5.20: E70T-5M J H4</td> </tr> <tr> <td>EN ISO</td> <td>17632-A: T 46 6 B M21 3 H5</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>1</td> </tr> </table> | AWS | A 5.20: E70T-5M J H4 | EN ISO | 17632-A: T 46 6 B M21 3 H5 | F-nr | 6 | FM | 1 | | | | | | | | | | | | | | | | | | | |
| AWS | A 5.20: E70T-5M J H4 | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| EN ISO | 17632-A: T 46 6 B M21 3 H5 | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| F-nr | 6 | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| FM | 1 | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| GEEIGNET FÜR | <p>Reh ≤ 460 MPa (67 ksi) ISO 15608: 1.2, 1.3, 2.1 1.5637, 1.6217, 1.6228, 1.0044-1.09821.0035 - 1.0570, 1.0345, 1.0425, 1.0481, 1.0308 - 1.0581, 1.0307 - 1.0582, 1.0440, 1.0472, 1.0475, 1.0416 to 1.0551 10Ni14, 12Ni14, 13MnNi6-3, 15NiMn6, S235JR-S355JR, S235JO-S355JO, S450JO, S235J2-S355J2, S275N-S460N, S275M-S460M, P235GH-P355GH, P275NL1-P460NL1, P215NL, P265NL, P355N, P285NH-P460NH, P195TR1-P265TR1, P195TR2-P265TR2, P195GH-P265GH, L245NB-L415NB, L450QB, L245MB-L450MB, GE200-GE240, A, B, D, E, A 32-E 36 ASTM A 106 Gr. A, B, C; A 181 Gr. 60, 70; A 283 Gr. A, C; A 285 Gr. A, B, C; A 350 Gr. LF1; A 414 Gr. A, B, C, D, E, F, G; A 501 Gr. B; A 513 Gr. 1018; A 516 Gr. 55, 60, 65, 70; A 573 Gr. 58, 65, 70; A 588 Gr. A, B; A 633 Gr. C, E; A 662 Gr. B; A 711 Gr. 1013; A 841 Gr. A; API 5 L Gr. B, X42, X52, X56, X60, X65 Domex 315-460MC, MC Plus, ML</p> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| ZULASSUNGEN | CE | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| SCHWEISSPOSITIONEN |  | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%) | <table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td style="width: 25%;">C</td> <td style="width: 25%;">Si</td> <td style="width: 25%;">Mn</td> <td style="width: 25%;">P</td> <td style="width: 25%;">S</td> </tr> <tr> <td>0.08</td> <td>0.5</td> <td>1.4</td> <td>0.015</td> <td>0.015</td> </tr> </table> | C | Si | Mn | P | S | 0.08 | 0.5 | 1.4 | 0.015 | 0.015 | | | | | | | | | | | | | | | | | |
| C | Si | Mn | P | S | | | | | | | | | | | | | | | | | | | | | | | | |
| 0.08 | 0.5 | 1.4 | 0.015 | 0.015 | | | | | | | | | | | | | | | | | | | | | | | | |
| MECHANISCHE GÜTEWERTE | <table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R_{p0,2} (MPa)</th> <th rowspan="2">R_m (MPa)</th> <th rowspan="2">A₅ (%)</th> <th colspan="3">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th>-20°C</th> <th>-40°C</th> <th>-60°C</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>500</td> <td>590</td> <td>28</td> <td>100</td> <td>65</td> <td>55</td> <td>HRc</td> </tr> <tr> <td>570°C- 620°C 1h</td> <td>510</td> <td>600</td> <td>30</td> <td>100</td> <td>65</td> <td>55</td> <td>HRc</td> </tr> </tbody> </table> | Heat Treatment | R _{p0,2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | | | Hardness | -20°C | -40°C | -60°C | As Welded | 500 | 590 | 28 | 100 | 65 | 55 | HRc | 570°C- 620°C 1h | 510 | 600 | 30 | 100 | 65 | 55 | HRc |
| Heat Treatment | R _{p0,2} (MPa) | | | | | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | | | Hardness | | | | | | | | | | | | | | | | | |
| | | -20°C | -40°C | -60°C | | | | | | | | | | | | | | | | | | | | | | | | |
| As Welded | 500 | 590 | 28 | 100 | 65 | 55 | HRc | | | | | | | | | | | | | | | | | | | | | |
| 570°C- 620°C 1h | 510 | 600 | 30 | 100 | 65 | 55 | HRc | | | | | | | | | | | | | | | | | | | | | |
| RÜCKTROCKNUNG | Not required | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| GAS ACC. EN ISO 14175 | M21, C1 | | | | | | | | | | | | | | | | | | | | | | | | | | | |



CEWELD AA B460

AA B460 1,2MM

| Packaging | KG/unit | EanCode |
|-----------|----------|---------------|
| D-200 | 20 (4x5) | 8720663405364 |
| K-300 | 16 | 8720663405357 |

AA B460 1,6MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| K-300 | 16 | 8720663423153 |