



CEWELD AA R460 LT

TYPE Rutile fluxcored wire with exceptional toughness down to -40°C.

APPLICATIONS Fully sealed cored wire for single or multi-pass welding of carbon, carbon-manganese steels and fine-grain structural steels using M21 (Ar/CO2) shielding gas. Steel construction, shipbuilding, pressure vessels, mechanical engineering, pipe work, offshore, crane building, heavy transport etc..

PROPERTIES Seamless rutile flux cored wire with excellent welding properties combined with extreme impact toughness down to -40°C. Fast freezing slag for economic welding in PF position up to 280 ampere without any spatters. Due to the seamless production process this wire is strongly recommended for atomized welding such as with robots. Due to the seamless production process the hydrogen content is below 3ml/100g weld metal even after long storage. CTOD tested.

CLASSIFICATION

AWS	A 5.20: E71T-9M-J H4
EN ISO	17632-A: T 46 4 Z P M21 1 H5
F-nr	6
FM	1

SUITABLE FOR **ReH ≤ 460 MPa (67 ksi) ISO 15608: 1.1, 1.2, 1.3, 2.1, 3.1 (ReH max. 485 MPa)**
 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

APPROVALS TÜV: 19710, CE, DNV

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

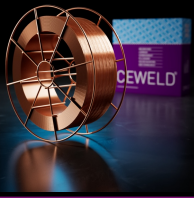
C	Si	Mn	Cr	Ni	Mo	Cu	P	S
0.04	0.4	1.3	0.03	0.42	0.01	0.2	0.011	0.006

MECHANICAL PROPERTIES

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V	Hardness
				-40°C	
As Welded	495	550	26	120	HRc

REDRYING Not required

GAS ACC. EN ISO 14175 M21



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AA R460 LT 1,2MM

Packaging	KG/unit	EanCode
D-200	5	8720682051306
BS-300	16	8720682051313