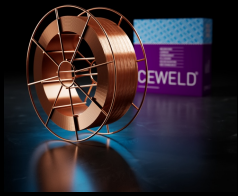




CEWELD AA R460

TYPE	Seamless micro-alloyed rutile flux-cored wire for CO2 and M21. (Type E 71 T1, T 46 4)																
APPLICATIONS	Fully sealed cored wire for single or multi-pass welding of carbon, carbon-manganese steels and fine-grain structural steels using 100% CO2 and Mixgas M21 (Ar/CO2) shielding gas. Shipbuilding, Steel structures, Offshore structures, Pipelines, Non-alloy and fine grain steels, Vessels, General fabrication, Heavy equipment, Single and multi-pass welding																
PROPERTIES	Excellent weld puddle manipulation due to fast freezing slag, superior out-of-position welding also at higher currents. Using temperature up to -40°C. Particularly suited for MAG-orbital welding and all-position welding on ceramic backing. Extreme low spatter loss, easy slag removal and hydrogen content below 3 ml/100g. even after long unconditioned storage.																
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.20: E71T-1M-J H4</td> </tr> <tr> <td>EN ISO</td> <td>17632-A: T 46 4 P M21 1 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: E71T-1M-J H4	EN ISO	17632-A: T 46 4 P M21 1 H5	F-nr	6	FM	1								
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EN ISO	17632-A: T 46 4 P M21 1 H5																
F-nr	6																
FM	1																
SUITABLE FOR	<p>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</p>																
APPROVALS	CE, TÜV: 12704, Lloyds, DNV																
WELDING POSITIONS																	
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>1.3</td> <td>0.015</td> <td>0.015</td> </tr> </table>	C	Si	Mn	P	S	0.08	0.5	1.3	0.015	0.015						
C	Si	Mn	P	S													
0.08	0.5	1.3	0.015	0.015													
MECHANICAL PROPERTIES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">Rp0,2 (MPa)</th> <th rowspan="2">Rm (MPa)</th> <th rowspan="2">A5 (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th>-20°C</th> <th>-40°C</th> </tr> <tr> <td>As Welded</td> <td>490</td> <td>580</td> <td>25</td> <td>90</td> <td>70</td> <td>HRc</td> </tr> </table>	Heat Treatment	Rp0,2 (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness	-20°C	-40°C	As Welded	490	580	25	90	70	HRc
Heat Treatment	Rp0,2 (MPa)					Rm (MPa)	A5 (%)		Impact Energy (J) ISO-V		Hardness						
		-20°C	-40°C														
As Welded	490	580	25	90	70	HRc											
REDRYING	Not required																
GAS ACC. EN ISO 14175	M21, C1																



CEWELD AA R460

AA R460 1,0MM

Packaging	KG/unit	EanCode
D-200	20 (4x5)	8720663423597
K-300	16	8720663423610

AA R460 1,2MM

Packaging	KG/unit	EanCode
BS-300	16	8720663423627
D-200	20 (4x5)	8720663423603

AA R460 1,4MM

Packaging	KG/unit	EanCode
K-300	16	8720663423634

AA R460 1,6MM

Packaging	KG/unit	EanCode
K-300	16	8720663423641