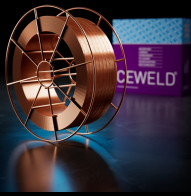




CEWELD AA M460

TYPE	Seamless metal-powder cored wire without slag for M21																											
APPLICATIONS	Steel construction, shipbuilding, pressure vessels, mechanical engineering, pipe work, offshore, crane building, heavy transport, lifting equipment etc.																											
PROPERTIES	Seamless metal cored wire with remarkable stable arc and no spatters. Excellent for use in automated welding applications such as orbital Mag or robotic welding. This wire offers a unique approval class at most third parties that enables you to use only one wire to cover more procedures up to 460 MPa yield strength steels. CEWELD AA M460 can also be used for constructions that needs post weld heat treatment after welding and still offers mechanical properties confirming 5Y46 class. Due to the seamless production process the hydrogen content is below 3ml/100gr weld metal even after long storage.																											
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.18: E70C-6M H4</td> </tr> <tr> <td>EN ISO</td> <td>17632-A: T 46 6 M 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 5.18: E70C-6M H4	EN ISO	17632-A: T 46 6 M M21 1 H5	F-nr	6	FM	1																			
AWS	A 5.18: E70C-6M H4																											
EN ISO	17632-A: T 46 6 M M21 1 H5																											
F-nr	6																											
FM	1																											
SUITABLE FOR	<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>																											
APPROVALS	TÜV: 12706, CE, Lloyds, DNV																											
WELDING POSITIONS																												
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> </tr> </thead> <tbody> <tr> <td>0.05</td> <td>0.7</td> <td>1.5</td> <td>0.015</td> <td>0.015</td> </tr> </tbody> </table>	C	Si	Mn	P	S	0.05	0.7	1.5	0.015	0.015																	
C	Si	Mn	P	S																								
0.05	0.7	1.5	0.015	0.015																								
MECHANICAL PROPERTIES	<table border="1"> <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>510</td> <td>620</td> <td>24</td> <td>100</td> <td>80</td> <td>55</td> <td>HRc</td> </tr> <tr> <td>580°C±15°C 2h</td> <td>475</td> <td>620</td> <td>26</td> <td>70</td> <td>60</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	510	620	24	100	80	55	HRc	580°C±15°C 2h	475	620	26	70	60	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	510	620	24	100	80	55	HRc																					
580°C±15°C 2h	475	620	26	70	60	55	HRc																					
REDRYING	Not required																											
GAS ACC. EN ISO 14175	M21																											



CEWELD AA M460

AA M460 1,0MM

Packaging	KG/unit	EanCode
BS-300	16	8720663423368
D-200	5	8720663423313

AA M460 1,2MM

Packaging	KG/unit	EanCode
BS-300	16	8720663423375
D-200	20 (4x5)	8720663423320
Drum	300	8720663423344

AA M460 1,6MM

Packaging	KG/unit	EanCode
D-760	270	8720663423337
Drum	250	8720663423351
K-300	16	8720663423382