




# CEWELD AA R400

TYPE	The ultimate seamless rutile flux-cored welding wire for shipbuilding E 71T-1																	
APPLICATIONS	Fully sealed cored wire for single or multi-pass welding of carbon, carbon-manganese steels and fine-grain structural steels using 100% CO 2 and M21 shielding gas Shipbuilding, steel and vessel construction, mechanical engineering and pipe work.																	
PROPERTIES	CEWELD® AA R400 is a seamless rutile cored wire with excellent welding properties in all positions. Due to the seamless concept, this wire offers full protection against moisture absorption and can be safely stored for long periods of time. CEWELD® AA R400 offers the best possible feeding characteristics even for long wire packages. Can be used for manual and (semi- and fully) mechanized welding. Good quality values down to -40°C. Low spatter losses with excellent slag removability. Also suitable for welding on ceramic backing.																	
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.20: E71T-1M-J H4</td> </tr> <tr> <td>AWS</td> <td>A 5.20: E71T-1C-J H4</td> </tr> <tr> <td>AWS</td> <td>A 5.36: E71T1-M21A4-CS1-H4</td> </tr> <tr> <td>EN ISO</td> <td>17632-A: T 46 4 P M21 1 H5</td> </tr> <tr> <td>EN ISO</td> <td>17632-A: T 42 2 P C1 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	AWS	A 5.20: E71T-1C-J H4	AWS	A 5.36: E71T1-M21A4-CS1-H4	EN ISO	17632-A: T 46 4 P M21 1 H5	EN ISO	17632-A: T 42 2 P C1 1 H5	F-nr	6	FM	1			
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SUITABLE FOR	<p><b>Reh ≤ 420 MPa (67 ksi) ISO 15608: 1.2, 1.3, 2.1</b>            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, Domex 315-420MC, MC Plus, ML</p>																	
APPROVALS	Lloyds TÜV (19710) CE 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>0.07</td> <td>0.5</td> <td>1.3</td> <td>0.015</td> <td>0.015</td> </tr> </table>	C	Si	Mn	P	S	0.07	0.5	1.3	0.015	0.015							
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ALL WELD MECHANICAL PROPERTIES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td rowspan="2" style="width: 15%;">Heat Treatment</td> <td style="width: 10%;">Rp0,2</td> <td style="width: 10%;">Rm</td> <td style="width: 10%;">A5</td> <td colspan="2" style="width: 55%;">Impact Energy (J) ISO-V</td> </tr> <tr> <td>MPa</td> <td>MPa</td> <td>(%)</td> <td style="width: 27.5%;">-20°C</td> <td style="width: 27.5%;">-40°C</td> </tr> <tr> <td>As Welded /</td> <td>450</td> <td>580</td> <td>23</td> <td>90</td> <td>70</td> </tr> </table>	Heat Treatment	Rp0,2	Rm	A5	Impact Energy (J) ISO-V		MPa	MPa	(%)	-20°C	-40°C	As Welded /	450	580	23	90	70
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	MPa	MPa	(%)	-20°C	-40°C													
As Welded /	450	580	23	90	70													
REDRYING TEMPERATURE	Not required																	
GAS ACCORDING EN 14175	M21, C1																	



# CEWELD AA R400

## AA R400 1,0MM

Type	KG/unit	EANCode
D-200	20 (4x5)	8720663423542

## AA R400 1,2MM

Type	KG/unit	EANCode
BS-300	16	8720663423573
BS-300	16	8720663423580
D-200	20 (4x5)	8720663423559
Drum	300	8720663423566