



CEWELD AA R400

TYPE	The ultimate seamless rutile flux-cored welding wire for shipbuilding. (E 71T-1, T 46 4(2) P)														
APPLICATIONS	CEWELD® AA R400 is a seamless flux cored electrode for single and multi-pass welding of unalloyed steels and fine-grained structural steels with mixed gas and 100% CO ₂ . For example in the following areas: steel construction, shipbuilding, pressure vessel construction, mechanical engineering, pipeline construction, offshore, bridge construction, heavy engineering, etc.														
PROPERTIES	CEWELD® AA R400 has excellent welding properties in all positions due to its rapidly solidifying slag. Thanks to its seamless design, this wire offers complete protection against moisture absorption and can be stored safely for long periods of time. CEWELD® AA R400 also offers the best feeding properties for long wire packages. Suitable for manual and mechanised welding. Good quality down to -40°C with mixed gas and -20°C with CO ₂ . Low spatter losses with excellent slag removability. Also suitable for welding on ceramic backing plates.														
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>ReH ≤ 460 MPa (67 ksi) ISO 15608: 1.2 (275 < ReH < 360 MPa), 1.3 (ReH > 360 MPa < 460 MPa) 1.0409, 1.0421, 1.0426, 1.0429, 1.0430, 1.0436, 1.0473, 1.0481, 1.0482, 1.0484, 1.0505, 1.0545, 1.0546, 1.0562, 1.0566, 1.0570, 1.0578, 1.0581, 1.0582, 1.1138, 1.5419, 1.8948, 1.8900, 1.8901, 1.8902, 1.8903, 1.8905, 1.8907, 1.8910, 1.8912, 1.8915, 1.8917, 1.8930, 1.8932, 1.8935, 1.8937, 1.8970, 1.8971, 1.8972 10Ni14, 12Ni14, 11MnNi5-3, 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 AH32, AH36, AH40; DH32, DH36, DH40; EH32, EH36, EH40; FH32, FH36, FH40 ASTM A 203 Gr. D, E; A 350 Gr. LF1, LF2, LF3; A 420 Gr. WPL3, WPL6; A 516 Gr. 60, 65, 70; A 572 Gr. 42, 50, 55, 60, 65; A 633 Gr. A, D, E; A 662 Gr. A, B, C; A 707 Gr. L1, L2, L3; A 738 Gr. A; A 841 A, B, C; API 5 L X52, X60, X65, X52Q, X60Q, X65Q Oceanfit 52, Oceanfit 60, Oceanfit 65, Oceanfit 355, Oceanfit 420, Oceanfit 460, alform plate 460M; durostat 400, 450, durostat B2</p>														
APPROVALS	Lloyds TÜV ((19710)) CE DNV BV														
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>0.07</td> <td>0.5</td> <td>1.3</td> <td>0.015</td> <td>0.015</td> </tr> </tbody> </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"> <thead> <tr> <th>Heat Treatment</th> <th>R_{p0,2} MPa</th> <th>R_m MPa</th> <th>A₅ (%)</th> </tr> </thead> <tbody> <tr> <td>As Welded /</td> <td>460</td> <td>580</td> <td>23</td> </tr> </tbody> </table>	Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	As Welded /	460	580	23						
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As Welded /	460	580	23												
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	250	8720663423566