



CEWELD AA M400

TYPE	Seamless metal cored wire without slag for M21																	
APPLICATIONS	Steel construction, shipbuilding, pressure vessels, mechanical engineering, pipe work, offshore, bridge building, heavy transport 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. CEWELD® AA M400 offers a more dense and higher filling rate to obtain better performance and productivity. CEWELD® AA M400 can be used in a wide range of parameters starting from short arc at 14 volts for root weld or thin plate welding up to 32 Volts for extreme deposition rates. Due to the seamless production process the hydrogen content is below 3ml/100gr weld metal even after long unconditioned storage.																	
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.18: E70C-6M H4</td> </tr> <tr> <td>AWS</td> <td>A 5.36: E71T15-M21A8-CS1-H4</td> </tr> <tr> <td>EN ISO</td> <td>17632-A: T 42 4 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	AWS	A 5.36: E71T15-M21A8-CS1-H4	EN ISO	17632-A: T 42 4 M M21 1 H5	F-nr	6	FM	1							
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EN ISO	17632-A: T 42 4 M M21 1 H5																	
F-nr	6																	
FM	1																	
SUITABLE FOR	<p>Reh ≤ 420 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, S420JO, S235J2-S355J2, S275N-S460N, S275M-S420M, P235GH-P355GH, P275NL1-P420NL1, P215NL, P265NL, P355N, P285NH-P460NH, P195TR1-P265TR1, P195TR2-P265TR2, P195GH-P265GH, L245NB-L415NB, L450QB, L245MB-L420MB, 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 (19711) CE 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							
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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%;">R_{P0,2}</td> <td style="width: 10%;">R_m</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 /1h</td> <td>450</td> <td>570</td> <td>24</td> <td>100</td> <td>70</td> </tr> </table>	Heat Treatment	R _{P0,2}	R _m	A ₅	Impact Energy (J) ISO-V		MPa	MPa	(%)	-20°C	-40°C	As Welded /1h	450	570	24	100	70
Heat Treatment	R _{P0,2}		R _m	A ₅	Impact Energy (J) ISO-V													
	MPa	MPa	(%)	-20°C	-40°C													
As Welded /1h	450	570	24	100	70													
REDRYING TEMPERATURE	Not required																	
GAS ACCORDING EN 14175	M21																	



CEWELD AA M400

AA M400 1,0MM

Type	KG/unit	EANCode
BS-300	16	8720663423283

AA M400 1,2MM

Type	KG/unit	EANCode
BS-300	16	8720663423276
BS-300	15	8720663423290
D-200	20 (4x5)	8720663423245
Drum	250	8720663423252

AA M400 1,4MM

Type	KG/unit	EANCode
K-300	16	8720663423306

AA M400 1,6MM

Type	KG/unit	EANCode
Drum	250	8720663423269