


<b>CATEGORY</b>	FCAW Flux-Cored																												
<b>TYPE</b>	Seamless metal cored wire without slag for M21																												
<b>APPLICATIONS</b>	Steel construction, shipbuilding, pressure vessels, mechanical engineering, pipe work, offshore, bridge building, heavy transport etc.																												
<b>PROPERTIES</b>	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.																												
<b>CLASSIFICATION</b>	AWS	A 5.18: E70C-6M H4																											
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	EN ISO	17632-A: T 42 4 M M21 1 H5																											
	F-nr	6																											
	FM	1																											
<b>SUITABLE FOR</b>	<b>Materials</b>	<b>DIN</b>	<b>EN</b>	<b>ASTM</b>																									
	shipbuilding	A, B, D, AH 32 - EH 36	A, B, D, AH 32 - EH 36	Typical																									
	Unalloyed steels	S185 - S355	S185 - S355	A 106 / A 333																									
	boiler steels	P235GH, P355GH	P235GH, P355GH	A 662 / A 387																									
	pipe steels	P235T1/T2, P460NL2	P235T1/T2, P460NL2	A 738 / A 612																									
	-	L210 - L445MB	L210 - L445MB	A 299																									
	Fine grain steels	S385-S420-S460QL1	S385-S420-S460QL1	-																									
	API-standard	X 42, X60	X 42, X60	-																									
<b>APPROVALS</b>	TÜV (19711) CE Lloyds DNV																												
<b>WELDING POSITIONS:</b>																													
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<b>GAS ACCORDING EN 14175</b>	M21																												