



CEWELD AA R460 LT

TYPE	Seamless micro-alloyed rutile flux-cored wire for M21. (Type E 71 T1, T 46 6)																						
APPLICATIONS	CEWELD® AA R460LT is a seamless rutile cored wire for single and multi-pass welding of carbon, carbon-manganese and fine-grain structural steels using the shielding gas mixture M21 (Ar/CO2). Main areas of application are: Shipbuilding, steel construction, offshore structures, pipelines, unalloyed steels and fine-grained structural steels in general, general manufacturing, heavy engineering, single and multi-layer welding.																						
PROPERTIES	CEWELD® AA R460LT has excellent weld pool handling and is ideal for welding in all positions, even at higher currents, thanks to the rapidly solidifying slag. The working temperature is up to -60°C. Particularly suitable for MAG orbital welding and for welding in all positions on ceramic weld pool backing. Extremely low spatter loss, easy slag removal and hydrogen content below 3 ml/100 g, even after long storage.																						
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.20: E71T-9M-J H4</td> </tr> <tr> <td>EN ISO</td> <td>17632-A: T 46 4 Z MnNi P 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 5.20: E71T-9M-J H4	EN ISO	17632-A: T 46 4 Z MnNi P M21 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, 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	TÜV ((19712)) CE DNV																						
WELDING POSITIONS																							
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>V</th> <th>Cu</th> <th>P</th> <th>S</th> <th>Nb</th> </tr> </thead> <tbody> <tr> <td>0.04</td> <td>0.4</td> <td>1.3</td> <td>0.03</td> <td>0.42</td> <td>0.01</td> <td>0.008</td> <td>0.2</td> <td>0.011</td> <td>0.006</td> <td>0.015</td> </tr> </tbody> </table>	C	Si	Mn	Cr	Ni	Mo	V	Cu	P	S	Nb	0.04	0.4	1.3	0.03	0.42	0.01	0.008	0.2	0.011	0.006	0.015
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REDRYING TEMPERATURE	Not required																						
GAS ACCORDING EN 14175	M21																						



CEWELD AA R460 LT

AA R460 LT 1,2MM

Type	KG/unit	EANCode
D-200	5	8720682051306
BS-300	16	8720682051313