CEWELD AA B460

certilas® THE FILLER METAL SPECIALIST

TYPE	High-basic seamless flux-cored wire for CO2 and M21
APPLICATIONS	Shipbuilding, bridge construction, steel construction, mechanical engineering, pressure vessels and boiler constructions, foundries.
PROPERTIES	Absolute crack resistant weld metal conditioned by the high-basic slag combined with ultra low hydrogen content (HD< 3 ml/100g). High mechanical properties also for single-sided welding on ceramics. X-ray-proof seams with low spatter loss. Suitable for high-carbon steels and welding critical mixed combinations. Metallurgical ideal filler metal for repair and production welding as well as for buffer layers.

CLASSIFICATION

AWS	A 5.20: E70T-5M J H4
AWS	A 5.36: E70T5-M21A8-CS1-H4
AWS	A 5.36: E70T5-1CA4-CS1-H4
EN ISO	17632-A: T 46 6 B M21 3 H5
EN ISO	17632-A: T 42 4 B C1 3 H5
F-nr	6
FM	1

SUITABLE FOR

Reh ≤ 460 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, 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, X65
Domex 315-460MC,MC Plus, ML

APPROVALS: CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S
0.08	0.5	1.4	0.015	0.015

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Impact Energy (J) ISO-V -20°C	-40°C	-60°C
As Welded /	500	590	28	100	65	55
570°C- 620°C /1h	510	600	30	100	65	55

REDRYING TEMPERATURE: Not required

GAS ACCORDING EN 14175: M21, C1

CEWELD AA B460

AA B460 1,2MM

Type	KG/unit	EANCode
D-200	20 (4x5)	8720663405364
K-300	16	8720663405357

AA B460 1,6MM

Type	KG/unit	EANCode
K-300	16	8720663423153