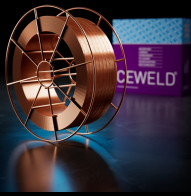




# CEWELD AA B460

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	<table border="0"> <tr> <td>AWS</td> <td>A 5.20: E70T-5M J H4</td> </tr> <tr> <td>AWS</td> <td>A 5.36: E70T5-M21A8-CS1-H4</td> </tr> <tr> <td>AWS</td> <td>A 5.36: E70T5-1CA4-CS1-H4</td> </tr> <tr> <td>EN ISO</td> <td>17632-A: T 46 6 B M21 3 H5</td> </tr> <tr> <td>EN ISO</td> <td>17632-A: T 42 4 B C1 3 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: 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										
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SUITABLE FOR	<p><b>Reh ≤ 460 MPa (67 ksi) ISO 15608: 1.2, 1.3, 2.1</b>            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</p>																								
APPROVALS	CE																								
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>1.4</td> <td>0.015</td> <td>0.015</td> </tr> </table>	C	Si	Mn	P	S	0.08	0.5	1.4	0.015	0.015														
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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