certilas® THE FILLER METAL SPECIALIST

CEWELD AA R460

TYPE

Seamless micro-alloyed rutile flux-cored wire for CO2 and M21. (Type E 71 T1, T 46 4)

APPLICATIONS

CEWELD® AA R460 is a seamless rutile cored wire for single and multi-pass welding of carbon, carbon-manganese and fine-grain structural steels using 100% CO2 and 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 R460 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 -40°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

AWS	A 5.20: E71T-1M-J H4
AWS	A 5.36: E71T1-M21A4-CS1-H4
AWS	A 5.36: E71T1-1CA0-CS1-H4
EN ISO	17632-A: T 46 4 P M21 1 H5
EN ISO	17632-A: T 42 2 P C1 1 H5
F-nr	6
FM	1

SUITABLE FOR

Reh ≤ 460 MPa 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
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

APPROVALS

CE TÜV (12704) Lloyds DNV

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S
0.08	0.5	1.3	0.015	0.015

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Impact Energy (J) ISO-V -20°C	Impact Energy (J) ISO-V -40°C
As Welded /	490	580	25	90	70

REDRYING TEMPERATURE

Not required

GAS ACCORDING EN 14175

M21, C1

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AA R460 1,0MM

Type	KG/unit	EANCode
D-200	20 (4x5)	8720663423597
K-300	16	8720663423610

AA R460 1,2MM

Type	KG/unit	EANCode
BS-300	16	8720663423627
D-200	20 (4x5)	8720663423603

AA R460 1,4MM

Type	KG/unit	EANCode
K-300	16	8720663423634

AA R460 1,6MM

Type	KG/unit	EANCode
K-300	16	8720663423641