CEWELD AA M460

certilas® THE FILLER METAL SPECIALIST

TYPE

Seamless metal-powder cored wire without slag for M21.(E 70C-6M, T 46 6 M)

APPLICATIONS

CEWELD AA M460 is suitable for welding applications such as MAG orbital or robotic welding. It has a wide range of approvals. This means that one wire can cover multiple applications up to a yield strength of 460 MPa. Applications include steel construction, shipbuilding, pressure vessel and mechanical engineering, pipeline construction, offshore, crane construction, heavy transport, lifting equipment, etc.

PROPERTIES

CEWELD AA M460 is a seamless metal powder cored wire with a remarkably stable arc with virtually no spatter. Excellent for use in automated welding machines.
CEWELD AA M460 can also be used for constructions that require heat treatment after welding and still offers very good mechanical properties, class 5Y46. Low hydrogen content HD<3 ml/100g even after long storage. CTOD tested at -20°C

CLASSIFICATION

AWS	A 5.18: E70C-6M H4
AWS	A 5.36: E81T15-M21A8-CS1-H4
EN ISO	17632-A: T 46 6 M M21 1 H5
F-nr	6
FM	1

SUITABLE FOR

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

APPROVALS

TÜV ((12706)) CE Lloyds DNV

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S
0.05	0.7	1.5	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 /	510	620	24	100	80	55
580°C±15°C /2h	475	620	26	70	60	55

REDRYING TEMPERATURE

Not required

GAS ACCORDING EN 14175

M21

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AA M460 1,0MM

Type	KG/unit	EANCode
BS-300	16	8720663423368
D-200	5	8720663423313

AA M460 1,2MM

Type	KG/unit	EANCode
BS-300	16	8720663423375
D-200	20 (4x5)	8720663423320
Drum	300	8720663423344

AA M460 1,6MM

Type	KG/unit	EANCode
D-760	270	8720663423337
Drum	250	8720663423351
K-300	16	8720663423382