



CEWELD AA M460

TYPE Seamless metal-powder cored wire without slag for M21

APPLICATIONS Steel construction, shipbuilding, pressure vessels, mechanical engineering, pipe work, offshore, crane building, heavy transport, lifting equipment etc.

PROPERTIES Seamless metal cored wire with remarkable stable arc and no spatters. Excellent for use in automated welding applications such as orbital Mag or robotic welding. This wire offers a unique approval class at most third parties that enables you to use only one wire to cover more procedures up to 460 MPa yield strength steels. CEWELD AA M460 can also be used for constructions that needs post weld heat treatment after welding and still offers mechanical properties confirming 5Y46 class. Due to the seamless production process the hydrogen content is below 3ml/100gr weld metal even after long storage.

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, 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 TÜV (12706) CE Lloyds DNV

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

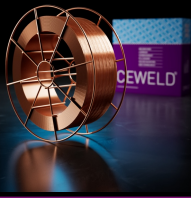
	C	Si	Mn	P	S
	0.05	0.7	1.5	0.015	0.015

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V		
				-20°C	-40°C	-60°C
As Welded / 580°C±15°C /2h	510 / 475	620 / 620	24 / 26	100 / 70	80 / 60	55 / 55

REDRYING TEMPERATURE Not required

GAS ACCORDING EN 14175 M21



CEWELD AA M460

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