

# CEWELD AA R460 LT

**TYPE** Rutile fluxcored wire with exceptional toughness down to -40°C.

**APPLICATIONS** Fully sealed cored wire for single or multi-pass welding of carbon, carbon-manganese steels and fine-grain structural steels using M21 ( Ar/CO2) shielding gas. Steel construction, shipbuilding, pressure vessels, mechanical engineering, pipe work, offshore, crane building, heavy transport etc..

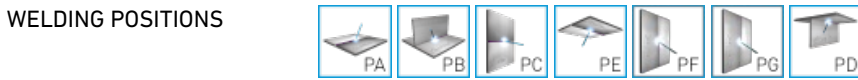
**PROPERTIES** Seamless rutile flux cored wire with excellent welding properties combined with extreme impact toughness down to -40°C. Fast freezing slag for economic welding in PF position up to 280 ampere without any spatters. Due to the seamless production process this wire is strongly recommended for atomized welding such as with robots. Due to the seamless production process the hydrogen content is below 3ml/100g weld metal even after long storage. CTOD tested.

**CLASSIFICATION**

AWS	A 5.20: E71T-9M-J H4
EN ISO	17632-A: T 46 4 Z P M21 1 H5
F-nr	6
FM	1

**SUITABLE FOR** **ReH ≤ 460 MPa (67 ksi) ISO 15608: 1.1, 1.2, 1.3, 2.1, 3.1 (ReH max. 485 MPa)**  
 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: 19710, CE, DNV



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

C	Si	Mn	Cr	Ni	Mo	Cu	P	S
0.04	0.4	1.3	0.03	0.42	0.01	0.2	0.011	0.006

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
				-40°C		
As Welded	495	550	26	120		HRc

**REDRYING** Not required

**GAS ACC. EN ISO 14175** M21



# CEWELD AA R460 LT

AA R460 LT 1,2MM

Packaging	KG/unit	EanCode
D-200	5	8720682051306
BS-300	16	8720682051313