CEWELD AA R460

certilas® THE FILLER METAL SPECIALIST

TYPE	Seamless micro-alloyed rutile flux-cored wire for CO2 and M21. (Type E 71 T1, T 46 4)
APPLICATIONS	Fully sealed cored wire for single or multi-pass welding of carbon, carbon-manganese steels and fine-grain structural steels using 100% CO2 and Mixgas M21 (Ar/CO2) shielding gas. Shipbuilding, Steel structures, Offshore structures, Pipelines, Non-alloy and fine grain steels, Vessels, General fabrication, Heavy equipment, Single and multi-pass welding
PROPERTIES	Excellent weld puddle manipulation due to fast freezing slag, superior out-of-position welding also at higher currents. Using temperature up to -40°C. Particularly suited for MAG-orbital welding and all-position welding on ceramic backing. Extreme low spatter loss, easy slag removal and hydrogen content below 3 ml/100g. even after long unconditioned storage.

CLASSIFICATION

AWS	A 5.20: E71T-1M-J H4
EN ISO	17632-A: T 46 4 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: 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

MECHANICAL PROPERTIES

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

REDRYING: Not required

GAS ACC. EN ISO 14175: M21, C1

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AA R460 1,0MM

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

AA R460 1,2MM

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

AA R460 1,4MM

Packaging	KG/unit	EanCode
K-300	16	8720663423634

AA R460 1,6MM

Packaging	KG/unit	EanCode
K-300	16	8720663423641