



CEWELD AA B460

TYPE	High-basic seamless flux-cored wire for CO2 and M21																											
APPLICATIONS	Shipbuilding, bridge construction, steel construction, mechanical engineering, pressure vessels and boiler constructions, foundries.																											
PROPERTIES	Absolute crack resistant weld metal conditioned by the high-basic slag combined with ultra low hydrogen content (HD< 3 ml/100g). High mechanical properties also for single-sided welding on ceramics. X-ray-proof seams with low spatter loss. Suitable for high-carbon steels and welding critical mixed combinations. Metallurgical ideal filler metal for repair and production welding as well as for buffer layers.																											
CLASSIFICATION	AWS A 5.20: E70T-5M J H4, A 5.36: E70T5-M21A8-CS1-H4, A 5.36: E70T5-1CA4-CS1-H4 EN ISO 17632-A: T 46 6 B M21 3 H5, 17632-A: T 42 4 B C1 3 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	CE																											
WELDING POSITIONS																												
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table><tr><th>C</th><th>Si</th><th>Mn</th><th>P</th><th>S</th></tr><tr><td>0.08</td><td>0.5</td><td>1.4</td><td>0.015</td><td>0.015</td></tr></table>	C	Si	Mn	P	S	0.08	0.5	1.4	0.015	0.015																	
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MECHANICAL PROPERTIES	<table><tr><th rowspan="2">Heat Treatment</th><th rowspan="2">R_{p0,2} (MPa)</th><th rowspan="2">R_m (MPa)</th><th rowspan="2">A₅ (%)</th><th colspan="3">Impact Energy (J) ISO-V</th><th rowspan="2">Hardness</th></tr><tr><th>-20°C</th><th>-40°C</th><th>-60°C</th></tr><tr><td>As Welded</td><td>500</td><td>590</td><td>28</td><td>100</td><td>65</td><td>55</td><td>HRc</td></tr><tr><td>570°C- 620°C 1h</td><td>510</td><td>600</td><td>30</td><td>100</td><td>65</td><td>55</td><td>HRc</td></tr></table>	Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness	-20°C	-40°C	-60°C	As Welded	500	590	28	100	65	55	HRc	570°C- 620°C 1h	510	600	30	100	65	55	HRc
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		-20°C	-40°C	-60°C																								
As Welded	500	590	28	100	65	55	HRc																					
570°C- 620°C 1h	510	600	30	100	65	55	HRc																					
REDRYING	Not required																											
GAS ACC. EN ISO 14175	M21, C1																											



CEWELD AA B460

AA B460 1,2MM

Packaging	KG/unit	EanCode
D-200	20 (4x5)	8720663405364
K-300	16	8720663405357

AA B460 1,6MM

Packaging	KG/unit	EanCode
K-300	16	8720663423153