



CEWELD AA R460 LT

TYPE	Rutile fluxcored wire with exceptional toughness down to -60°C										
APPLICATIONS	Steel construction, shipbuilding, pressure vessels, mechanical engineering, pipe work, offshore, crane building, heavy transport etc..										
PROPRIÉTÉS	Seamless rutile flux cored wire with excellent welding properties combined with extreme impact toughness down to -60°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.										
CLASSIFICATION	AWS	A 5.20: E71T-9M-J H4									
	EN ISO	17632-A: T 46 4 Z MnNi P M21 1 H5									
	F-nr	6									
	FM	1									
CONVIENT POUR	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										
AGRÉMENTS	TÜV: (19712), CE, DNV										
POSITIONS DE SOUDAGE											
ANALYSE CHIMIQUE TYPIQUE DU MÉTAL DE SOUDURE (%)	C	Si	Mn	Cr	Ni	Mo	V	Cu	P	S	Nb
	0.04	0.4	1.3	0.03	0.42	0.01	0.008	0.2	0.011	0.006	0.015
PROPRIÉTÉS MÉCANIQUES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V				Hardness		
					-40°C		-60°C				
	As Welded	495	550	26	120		60		HRc		
ETUVAGE	Not required										
GAS ACC. EN ISO 14175	M21										



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AA R460 LT 1,2MM

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