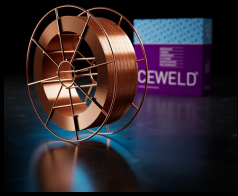




# CEWELD AA B460

| 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<br>EN ISO 17632-A: T 46 6 B M21 3 H5, 17632-A: T 42 4 B C1 3 H5<br>F-nr 6<br>FM 1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                |                         |                      |                    |                         |                    |                         |          |       |          |       |           |     |     |    |     |    |    |     |                 |     |     |    |     |    |    |     |
| SUITABLE FOR                                | <b>Reh ≤ 460 MPa (67 ksi) ISO 15608: 1.2, 1.3, 2.1</b><br>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<br>10Ni14, 12Ni14, 13MnNi6-3, 15NiMn6,<br>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,<br>A, B, D, E, A 32-E 36<br>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<br>Domex 315-460MC,MC Plus, ML |                |                         |                      |                    |                         |                    |                         |          |       |          |       |           |     |     |    |     |    |    |     |                 |     |     |    |     |    |    |     |
| APPROVALS                                   | CE                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                |                         |                      |                    |                         |                    |                         |          |       |          |       |           |     |     |    |     |    |    |     |                 |     |     |    |     |    |    |     |
| WELDING POSITIONS                           | <div></div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                |                         |                      |                    |                         |                    |                         |          |       |          |       |           |     |     |    |     |    |    |     |                 |     |     |    |     |    |    |     |
| 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    |       |           |     |     |    |     |    |    |     |                 |     |     |    |     |    |    |     |
| C                                           | Si                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | Mn             | P                       | S                    |                    |                         |                    |                         |          |       |          |       |           |     |     |    |     |    |    |     |                 |     |     |    |     |    |    |     |
| 0.08                                        | 0.5                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | 1.4            | 0.015                   | 0.015                |                    |                         |                    |                         |          |       |          |       |           |     |     |    |     |    |    |     |                 |     |     |    |     |    |    |     |
| MECHANICAL PROPERTIES                       | <table><tr><th rowspan="2">Heat Treatment</th><th rowspan="2">R<sub>p0,2</sub> (MPa)</th><th rowspan="2">R<sub>m</sub> (MPa)</th><th rowspan="2">A<sub>5</sub> (%)</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 <sub>p0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | 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 |
| Heat Treatment                              | R <sub>p0,2</sub> (MPa)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                |                         |                      |                    | R <sub>m</sub> (MPa)    | A <sub>5</sub> (%) | 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                |                         |          |       |          |       |           |     |     |    |     |    |    |     |                 |     |     |    |     |    |    |     |
| 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 |