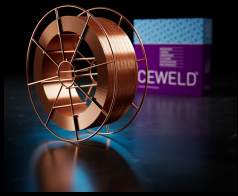




# CEWELD AA R460 LT

|                                             |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                   |                      |                    |                         |      |       |     |          |       |       |
|---------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------|----------------------|--------------------|-------------------------|------|-------|-----|----------|-------|-------|
| TYPE                                        | Rutiel gevulde draad met uitzonderlijke kerftaaiheid tot -60°C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                   |                      |                    |                         |      |       |     |          |       |       |
| TOEPASSINGEN                                | Staalbouw, scheepsbouw, drukvaten, machinebouw, leidingwerk, offshore, kranenbouw, zwaar transport enz.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                   |                      |                    |                         |      |       |     |          |       |       |
| EIGENSCHAPPEN                               | Naadloze rutiel gevulde draad met uitstekende laseigenschappen gecombineerd met extreme kerftaaiheid tot -60°C. Snelstollende slak voor economisch lassen in PF-positie tot 280 ampère zonder spatten. Door het naadloze productieproces wordt deze draad sterk aanbevolen voor geatomiseerd lassen zoals met robots. Door het naadloze productieproces is het waterstofgehalte lager dan 3 ml/100 g lasmetaal, zelfs na lange opslag.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                   |                      |                    |                         |      |       |     |          |       |       |
| CLASSIFICATIE                               | 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                                 |                      |                    |                         |      |       |     |          |       |       |
| GESCHIKT VOOR                               | <b>Reh ≤ 460 MPa (67 ksi) ISO 15608: 1.2 (275 &lt; Reh &lt; 360 MPa), 1.3 (ReH &gt; 360 MPa &lt; 460 MPa)</b><br>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<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>AH32, AH36, AH40; DH32, DH36, DH40; EH32, EH36, EH40; FH32, FH36, FH40<br>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<br>Oceanfit 52, Oceanfit 60, Oceanfit 65, Oceanfit 355, Oceanfit 420, Oceanfit 460, alform plate 460M; durostat 400, 450, durostat B2 |                                   |                      |                    |                         |      |       |     |          |       |       |
| GOEDKEURINGEN                               | TÜV: (19712), CE, DNV                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                   |                      |                    |                         |      |       |     |          |       |       |
| LASPOSITIES                                 | <div></div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                                   |                      |                    |                         |      |       |     |          |       |       |
| TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%) | 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 |
| MECHANISCHE WAARDEN                         | 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                   |      | -60°C |     |          |       |       |
|                                             | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | 495                               | 550                  | 26                 | 120                     |      | 60    |     | HRc      |       |       |
| HERDROGEN                                   | 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 |