



CEWELD AA R460 LT

TYPE Seamless micro-alloyed rutile flux-cored wire for M21. (Type E 71 T1, T 46 6)

APPLICATIONS CEWELD® AA R460LT is a seamless rutile cored wire for single and multi-pass welding of carbon, carbon-manganese and fine-grain structural steels using the shielding gas mixture M21 (Ar/CO2). Main areas of application are: Shipbuilding, steel construction, offshore structures, pipelines, unalloyed steels and fine-grained structural steels in general, general manufacturing, heavy engineering, single and multi-layer welding.

PROPERTIES CEWELD® AA R460LT has excellent weld pool handling and is ideal for welding in all positions, even at higher currents, thanks to the rapidly solidifying slag. The working temperature is up to -60°C. Particularly suitable for MAG orbital welding and for welding in all positions on ceramic weld pool backing. Extremely low spatter loss, easy slag removal and hydrogen content below 3 ml/100 g, 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

SUITABLE FOR **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

APPROVALS TÜV: (19712), CE, DNV

WELDING POSITIONS



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

MECHANICAL PROPERTIES

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

REDRYING 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