

AA B460

CATEGORY FCAW Flux-Cored

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 (<3ml). High mechanical properties also for single-sided weldings 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 weldings as well as for buffer layers.

CLASSIFICATION

AWS	5.20: E70 T5M-J H4 5.20 M: E490 T5M-J H4
EN ISO	17632-A: T 46 6 B M 3 H5 17632-B: T 556T5 OMA H5

SUITABLE FOR	Materials	DIN	EN	ASTM
shipbuilding	Unalloyed steels	A, B, D, E, AH 32 - EH 36	same	Typical
boiler steels	pipe steels	St 33, St 37-2 - St 52-3	S185 - S355	A 258 / A 516
-	-	H I, H III, 17Mn4, 19Mn5	P235GH, P355GH	A 662 / A 387
Fine grain steels	-	St 35.8, St 45.8	P235T1/T2, P460NL2	A 738 / A 612
API-standard	-	StE 210.7 TM, StE 445.7 TM	L210 - L445MB	A 299
		StE 255 to StE 460	S235 - S460QL1	-
		X 42, X65, X 70	X 42, X65, X 70	-

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS % WITH M21

C	Mn	Si	P	S
0.05	1.4	0.4	< 0.015	< 0.015

MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
				-20°C	-40°C	-60°C	
AW and SR	> 460	510-630	> 24	> 100	> 60	>47	

AW: as welded, SR: stress relieved

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet
1.2	23-33	230-330	D-200	5	1000
1.2	23-33	230-330	K-300	16	1024
1.6	25-34	250-380	K-300	16	1024

REDRYING TEMPERATURE not required

GAS ACC. EN ISO 14175: M21