

## AA R400

**CATEGORY** FCAW Flux-Cored

**TYPE** Seamless copper coated rutile flux-cored wire for CO2 and M21.

**APPLICATIONS** Shipbuilding, steel and vessel construction, mechanical engineering and pipe work.

**PROPERTIES** Seamless fluxcored wire with excellent welding properties in all positions. Due to the seamless concept this wire offers full protection against moisture pickup and can be stored for longer periods. Seamless fluxcored welding wires offers the best possible feeding properties that allows you to use longer torches. Applicable for hand and (semi)-mechanized welding. Good performance down to -40°C. Low spatter loss and excellent slag removal. Also suitable for welding on ceramic backing and root runs without backing.

**CLASSIFICATION**

AWS	A 5.20: E71T-1M-J H4 A 5.36: E71T1-M21 A4-CS1-H4
EN ISO	17632-A: T 46 4 P M 1 H5 17632-A: T 46 2 P C 1 H5

SUITABLE FOR	Materials	DIN	EN	ASTM
	shipbuilding	A, B, D, E, AH 32 - EH 36	same	Typical
	Unalloyed steels	St 33, St 37-2 - St 52-3	S185 - S355	A 258 / A 516
	boiler steels	H I, H III, 17Mn4, 19Mn5	P235GH, P355GH	A 662 / A 387
	pipe steels	St 35.8, St 45.8	P235T1/T2, P460NL2	A 738 / A 612
	-	StE 210.7 TM, StE 445.7 TM	L210 - L445MB	A 299
	Fine grain steels	StE 255 to StE 460	S235-S355-S460QL1	-
	API-standard	X 42, X60	X 42, X60	-
	Domex 460 MC			

**APPROVALS** DNV-GL, Lloyds (LR), CE approved

**WELDING POSITIONS:**



**WELD METAL ANALYSIS % (TYPICAL VALUES FOR M21)**

C	Mn	Si	P	S
0.08	1.3	0.5	<0.015	<0.015

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				-20°C	-40°C	-60°C	
AW (M21)	>460	530-680	>22	>60	>47		
AW (100% Co2)	>420	500-670	>22	>52	>42		

AW: as welded

**WELDING PARAMETERS / PACKING**

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A) DC+	spool type	kg / spool / drum	kg / pallet
1.2	22-30	150-300	D-200 / BS-300 / Drum	5 / 15 / 250	900 / 1080 / 1000

**REDRYING TEMPERATURE** Not required

**GAS ACC. EN ISO 14175:** M21