

AA M400

CATEGORY FCAW Flux-Cored

TYPE Seamless metal cored wire without slag for M21

APPLICATIONS Steel construction, shipbuilding, pressure vessels, mechanical engineering, pipe work, offshore, bridge building, heavy transport etc.

PROPERTIES Seamless metal cored wire with remarkable stable arc and no spatters. Excellent for use in automated welding applications such as orbital MAG or robotic welding. AA M400 is rolled instead of drawn that results in a more dense and higher filling grade to obtain better performance and productivity. AA M400 can be used in a wide range of parameters starting from short arc at 14 volts for root weld or thin plate welding up to 32 Volts for extreme deposition rates. Due to the seamless production process the hydrogen content is below 4ml/100gr weld metal even after long unconditioned storage.

CLASSIFICATION AWS 5.18: E 70C-6M H4
EN ISO 17632-A: T 46 4 M M1H5

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
-	Fine grain steels	H I, H III, 17Mn4, 19Mn5	P235GH, P355GH	A 662 / A 387
API-standard	API-standard	St 35.8, St 45.8	P235T1/T2, P420NL2	A 738 / A 612
		StE 210.7 TM, StE 445.7 TM	L210 - L445MB	A 299
		StE 255 to StE 420	S235-S420-S420QL1	-
		X 42, X65	X 42, X65	-

APPROVALS DNV-GL, CE approved

WELDING POSITIONS:



PURE WELD DEPOSIT WITH M21 MIXED GAS

C	Mn	Si	P	S
<0.10	1,2-1,6	0,35-0,8	<0,015	<0,015

TYPICAL MECHANICAL PROPERTIES UNDER M21

Heat treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact energy (J) ISO-V			Hardness HRc / HV
				-20°C	-40°C	-60°C	
AW	>460	530-680	>25	170	150		

AW: as welded

WELDING PARAMETERS / PACKING

parameters			packing		
D (mm)	Voltage (V)	Current (A) DC+	Spools / Drums	kg / spools	Kg per pallet
1.2	14-34	70-320	BS-300	15	1080

REDRYING TEMPERATURE not required

GAS ACC. EN ISO 14175: M21