



CEWELD AA M460

TYPE	Seamless metal-powder cored wire without slag for M21.(E 70C-6M, T 46 6 M)							
APPLICATIONS	CEWELD AA M460 is suitable for welding applications such as MAG orbital or robotic welding. It has a wide range of approvals. This means that one wire can cover multiple applications up to a yield strength of 460 MPa. Applications include steel construction, shipbuilding, pressure vessel and mechanical engineering, pipeline construction, offshore, crane construction, heavy transport, lifting equipment, etc.							
PROPERTIES	CEWELD AA M460 is a seamless metal powder cored wire with a remarkably stable arc with virtually no spatter. Excellent for use in automated welding machines. CEWELD AA M460 can also be used for constructions that require heat treatment after welding and still offers very good mechanical properties, class 5Y46. Low hydrogen content HD<3 ml/100g even after long storage. CTOD tested at -20°C							
CLASSIFICATION	AWS	A 5.18: E70C-6M H4, A 5.36: E81T15-M21A8-CS1-H4						
	EN ISO	17632-A: T 46 6 M 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: (12706), CE, Lloyds, DNV							
WELDING POSITIONS								
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S			
	0.05	0.7	1.5	0.015	0.015			
MECHANICAL PROPERTIES	Heat Treatment	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness
					-20°C	-40°C	-60°C	
	As Welded	510	620	24	100	80	55	HRc
	580°C±15°C 2h	475	620	26	70	60	55	HRc
REDRYING	Not required							
GAS ACC. EN ISO 14175	M21							



CEWELD AA M460

AA M460 1,0MM

Packaging	KG/unit	EanCode
BS-300	16	8720663423368
D-200	5	8720663423313

AA M460 1,2MM

Packaging	KG/unit	EanCode
BS-300	16	8720663423375
D-200	20 (4x5)	8720663423320
Drum	300	8720663423344

AA M460 1,6MM

Packaging	KG/unit	EanCode
D-760	270	8720663423337
Drum	250	8720663423351
K-300	16	8720663423382