CEWELD AA M400

certilas® THE FILLER METAL SPECIALIST

TYPE

Seamless metal cored wire without slag for M21.(E 70C-6M, T 42/46 4 M)

APPLICATIONS

CEWELD® AA M400 is ideal for automated welding applications such as MAG orbital or robot welding.
For example in steel construction, shipbuilding, pressure vessel construction, mechanical engineering, pipeline construction, offshore, bridge construction, heavy machinery construction, etc.

PROPERTIES

CEWELD® AA M400 is a seamless metal powder wire with remarkable arc stability and virtually no spatter. The wire offers improved performance and therefore productivity. CEWELD® AA M400 can be used in a wide range of parameters, from short arc at 14 volts for root pass or thin plate welding up to 32 volts for high deposition rates. Due to the seamless manufacturing process, the hydrogen content is less than 3 ml/100 g of weld metal even after long unconditioned storage.

CLASSIFICATION

AWS	A 5.18: E70C-6M H4, A 5.36: E71T15-M21A8-CS1-H4
EN ISO	17632-A: T 46 4 M M21 1 H5, 17632-A: T 42 4 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: 19711, CE, Lloyds, DNV

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S
0.08	0.5	1.3	0.015	0.015

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				-40°C	-20°C	
As Welded	510	610	25	70	100	HRc

REDRYING

Not required

GAS ACC. EN ISO 14175

M21

CEWELD AA M400

AA M400 1,0MM

Packaging	KG/unit	EanCode
BS-300	16	8720663423283

AA M400 1,2MM

Packaging	KG/unit	EanCode
BS-300	16	8720663423276
BS-300	15	8720663423290
D-200	20 (4x5)	8720663423245
Drum	250	8720663423252

AA M400 1,4MM

Packaging	KG/unit	EanCode
K-300	16	8720663423306

AA M400 1,6MM

Packaging	KG/unit	EanCode
Drum	250	8720663423269