

AA R400

CATEGORIE 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.

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	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	API-standard	St 35.8, St 45.8	P235T1/T2, P460NL2	A 738 / A 612
Domex 460 MC	Domex 460 MC	StE 210.7 TM, StE 445.7 TM	L210 - L445MB	A 299
		StE 255 to StE 460	S235-S355-S460QL1	-
		X 42, X60	X 42, X60	-

APPROVALS DNV-GL, CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS % (TYPICAL VALUES FOR M21)

C	Mn	Si	Cr	Ni	Mo	P	S
0.08	1.3	0.5	0.02	-	-	<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	>460	530-680	>22	>60	>47		

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	23-30	150-300	D-200	5	900

REDRYING TEMPERATURE Not required

GAS ACC. EN ISO 14175: M21