CEWELD AA R400

certilas® THE FILLER METAL SPECIALIST

TYPE	The ultimate seamless rutile flux-cored welding wire for shipbuilding E 71T-1
APPLICATIONS	Fully sealed cored wire for single or multi-pass welding of carbon, carbon-manganese steels and fine-grain structural steels using 100% CO 2 and M21 shielding gas Shipbuilding, steel and vessel construction, mechanical engineering and pipe work.
PROPERTIES	CEWELD® AA R400 is a seamless rutile cored wire with excellent welding properties in all positions. Due to the seamless concept, this wire offers full protection against moisture absorption and can be safely stored for long periods of time. CEWELD® AA R400 offers the best possible feeding characteristics even for long wire packages. Can be used for manual and (semi- and fully) mechanized welding. Good quality values down to -40°C. Low spatter losses with excellent slag removability. Also suitable for welding on ceramic backing.

CLASSIFICATION

AWS	A 5.20: E71T-1M-J H4
EN ISO	17632-A: T 46 4 P M21 1 H5
F-nr	6
FM	1

SUITABLE FOR

Reh ≤ 420 MPa (67 ksi) ISO 15608: 1.2, 1.3, 2.1
1.5637, 1.6217, 1.6228, 1.0044-1.09821.0035 - 1.0570, 1.0345, 1.0425, 1.0481, 1.0308 - 1.0581, 1.0307 - 1.0582, 1.0440, 1.0472, 1.0475, 1.0416 to 1.0551
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,
A, B, D, E, A 32-E 36
ASTM A 106 Gr. A, B, C; A 181 Gr. 60, 70; A 283 Gr. A, C; A 285 Gr. A, B, C; A 350 Gr. LF1; A 414 Gr. A, B, C, D, E, F, G; A 501 Gr. B; A 513 Gr. 1018; A 516 Gr. 55, 60, 65, 70; A 573 Gr. 58, 65, 70; A 588 Gr. A, B; A 633 Gr. C, E; A 662 Gr. B; A 711 Gr. 1013; A 841 Gr. A; API 5 L Gr. B, X42, X52, X56, X60,
Domex 315-420MC,MC Plus, ML

APPROVALS: Lloyds, TÜV: 19710, CE, DNV

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S
0.07	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
				-20°C	-40°C	
As Welded	450	580	23	90	70	HRc

REDRYING: Not required

GAS ACC. EN ISO 14175: M21, C1

CEWELD AA R400

AA R400 1,0MM

Packaging	KG/unit	EanCode
D-200	20 (4x5)	8720663423542

AA R400 1,2MM

Packaging	KG/unit	EanCode
BS-300	16	8720663423573
BS-300	16	8720663423580
D-200	20 (4x5)	8720663423559
Drum	300	8720663423566