

## AA B460

<b>CATEGORY</b>	FCAW Flux-Cored																																
<b>TYPE</b>	High-basic seamless flux-cored wire for CO2 and M21																																
<b>APPLICATIONS</b>	Shipbuilding, bridge construction, steel construction, mechanical engineering, pressure vessels and boiler constructions, foundries.																																
<b>PROPERTIES</b>	Absolute crack resistant weld metal conditioned by the high-basic slag combined with ultra low hydrogen content (<3ml). High mechanical properties also for single-sided weldings on ceramics. X-ray-proof seams with low spatter loss. Suitable for high-carbon steels and welding critical mixed combinations. Metallurgical ideal filler metal for repair and production weldings as well as for buffer layers.																																
<b>CLASSIFICATION</b>	AWS	5.20: E70 T5M-J H4 5.20 M: E490 T5M-J H4																															
	EN ISO	17632-A: T 46 6 B M 3 H5 / T 42 4 B C 3 H5 17632-B: T 556T5 0MA H5																															
<b>SUITABLE FOR</b>	<b>Materials</b>	<b>DIN</b>	<b>EN</b>	<b>ASTM</b>																													
	shipbuilding	A, B, D, E, AH 32 - EH 36	same	Typical																													
	Unalloyed steels	St 33, St 37-2 - St 52-3	S185 - S355	A 258 / A 516																													
	boiler steels	H I, H III, 17Mn4, 19Mn5	P235GH, P355GH	A 662 / A 387																													
	pipe steels	St 35.8, St 45.8	P235T1/T2, P460NL2	A 738 / A 612																													
	-	StE 210.7 TM, StE 445.7 TM	L210 - L445MB	A 299																													
	Fine grain steels	StE 255 to StE 460	S235 - S460QL1	-																													
	API-standard	X 42, X65, X 70	X 42, X65, X 70	-																													
<b>APPROVALS</b>	CE approved																																
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<b>WELD METAL ANALYSIS % WITH M21</b>	<table border="1"> <thead> <tr> <th>C</th> <th>Mn</th> <th>Si</th> <th>P</th> <th>S</th> </tr> </thead> <tbody> <tr> <td>0.05</td> <td>1.4</td> <td>0.4</td> <td>&lt; 0.015</td> <td>&lt; 0.015</td> </tr> </tbody> </table>					C	Mn	Si	P	S	0.05	1.4	0.4	< 0.015	< 0.015																		
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<b>REDRYING TEMPERATURE</b>	Not required																																
<b>GAS ACC. EN ISO 14175:</b>	M21																																