

AA M3Y

CATEGORY	FCAW Flux-Cored
TYPE	Metal-powder cored wire without slag for M21
APPLICATIONS	Steel construction, shipbuilding, pressure vessels, mechanical engineering, pipe work etc.
PROPERTIES	AA M3Y is a metal- cored wire which combines high deposition rate typical for FCW with the high efficiencies of solid wire, provides exceptionally smooth and stable arc, low spatter and minimal slag coverage. Extreme low silicate residues on the weld seam.

CLASSIFICATION	AWS EN ISO	A 5.18: E 70C-6M 17632-A: T 42 2 MM 3 H5
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SUITABLE FOR	Steel type:	DIN:	W.Nr.:
	Unalloyed steels:	St 33 to St 52.3	1.0035 to 1.0570
	Boiler plates:	HI, HII, 17 Mn4	1.0345, 1.0425, 1.0481
	Pipe steels:	St 35 to St 52.4	1.0308 to 1.0581
	-	StE 210.7 to StE 360.7	1.0307 to 1.0582
	Shipbuilding plates:	A, B, D	1.0440, 1.0472, 1.0475
	Steel castings:	GS-38 to GS-52	1.0416 to 1.0551
	Thin sheets:	1623/1	-

APPROVALS	TUV, DNV, Lloyds, CE in progress
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WELDING POSITIONS:	
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TYPICAL WELD DEPOSIT WITH M21 MIXED GAS				
C	Mn	Si	P	S
0.05	1,45	0.55	<0,011	<0,010

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	-30°C	-60°C	
AW	>400	>490	>22		>27		

AW: as welded

WELDING PARAMETERS / PACKING					
parameters			packing		
D (mm)	Voltage (V)	Current (A) DC+	Spools / Drums	kg / spools	Kg per pallet
1,2 mm	24-31	230-300	D-200 / KD-300 / POP	5 / 15 / 250	1200 - 1080 - 500
1,6 mm	28-33	290-360	D-200 / KD-300 / POP	5 / 15 / 250	1200 - 1080 - 500

REDRYING TEMPERATURE	NA
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GAS ACC. EN ISO 14175:	M21
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