

## AA M4Y

<b>CATEGORY</b>	FCAW Flux-Cored
<b>TYPE</b>	Metal-powder cored wire without slag for M21 mixed gas with extreme deposition rate and high current capability.
<b>APPLICATIONS</b>	Steel construction, shipbuilding, pressure vessels, mechanical engineering, pipe work etc.
<b>PROPERTIES</b>	AA M4Y 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.

<b>CLASSIFICATION</b>	AWS EN ISO	A 5.18: E 70C-6M 17632-A: T 42 4 MM 3 H5
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<b>SUITABLE FOR</b>	<b>Steel type:</b>	<b>DIN:</b>	<b>W.Nr.:</b>
	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	-

<b>APPROVALS</b>	TUV, DNV, Lloyds, CE in progress
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<b>WELDING POSITIONS:</b>	
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### TYPICAL WELD DEPOSIT WITH M21 MIXED GAS

C	Mn	Si	P	S
0.05	1,45	0.63	<0,011	<0,010

### MECHANICAL PROPERTIES

Heat treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact energy (J) ISO-V			Hardness HRc / HV
				-20°C	-40°C	-60°C	
AW	>420	>500	>20		>47		

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	25-35	150-300	D-200 / KD-300 / POP	5 / 15 / 250	1200 - 1080 - 500
1,6 mm	31-43	290-450	D-200 / KD-300 / POP	5 / 15 / 250	1200 - 1080 - 500

<b>REDRYING TEMPERATURE</b>	NA
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<b>GAS ACC. EN ISO 14175:</b>	M21
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