

AA R3Y

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| CATEGORY | FCAW Flux-Cored |
| TYPE | Rutile flux cored wire with slag support for M21 mixed gas with excellent welding properties in all positions. |
| APPLICATIONS | Steel construction, shipbuilding, pressure vessels, mechanical engineering, pipe work etc. |
| PROPERTIES | AA R3Y is a rutile flux cored wire which offers high deposition rate in PF position with smooth and stable arc, low spatter and fast freezing slag coverage. |

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| CLASSIFICATION | AWS | A 5.20: E 71T-1M |
| | EN ISO | 17632-A: T 42 2 PM 1 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 | - |

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| 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 | Cr | Ni | Mo | P | S |
| 0.05 | 1,22 | 0.48 | - | - | - | <0,013 | <0,009 |

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 | >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 | 20-33 | 150-300 | D-200 / KD-300 / POP | 5 / 15 / 250 | 1200 - 1080 - 500 |
| 1,6 mm | 23-43 | 200-450 | D-200 / KD-300 / POP | 5 / 15 / 250 | 1200 - 1080 - 500 |

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| REDRYING TEMPERATURE | NA |
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| GAS ACC. EN ISO 14175: | M21 |
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