

AA R400

CATEGORY FCAW Flux-Cored

TYPE Seamless copper coated rutile flux-cored wire for CO2 and M21.

APPLICATIONS Shipbuilding, steel and vessel construction, mechanical engineering and pipe work.

PROPERTIES Seamless fluxcored wire with excellent welding properties in all positions. Due to the seamless concept this wire offers full protection against moisture pickup and can be stored for longer periods. Seamless fluxcored welding wires offers the best possible feeding properties that allows you to use longer torches. Applicable for hand and (semi)-mechanized welding. Good performance down to -40°C. Low spatter loss and excellent slag removal. Also suitable for welding on ceramic backing and root runs without backing.

CLASSIFICATION

AWS	A 5.20: E71T-1M-J H4 A 5.20: E71T-1C-JH4 A 5.36: E71T1-M21 A4-CS1-H4 A 5.36: E71T-1C-A0-CS1-H4
EN ISO	17632-A: T 46 4 P M 1 H5 17632-A: T 46 2 P C 1 H5

SUITABLE FOR	Materials	DIN	EN	ASTM
shipbuilding	Unalloyed steels	A, B, D, AH 32 - EH 36	A, B, D, AH 32 - EH 36	Typical
boiler steels	pipe steels	S185 - S355	S185 - S355	A 106 / A 333
-	-	P235GH, P355GH	P235GH, P355GH	A 662 / A 387
Fine grain steels	-	P235T1/T2, P460NL2	P235T1/T2, P460NL2	A 738 / A 612
API-standard	-	L210 - L445MB	L210 - L445MB	A 299
Domex 460 MC	-	S385-S460QL1	S385-S460QL1	-
		X 42, X60	X 42, X60	-

APPROVALS DNV-GL, Lloyds (LR) in progress, CE

WELDING POSITIONS:



WELD METAL ANALYSIS % (TYPICAL VALUES FOR M21)

C	Mn	Si	P	S
0.08	1.3	0.5	<0.015	<0.015

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness H _{Rc} / HV
				-20°C	-40°C	-60°C	
AW (M21)	>460	530-680	>22	>90	>70		
AW (100% Co2)	>420	500-670	>22	>70	>42		

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A) DC+	spool type	kg / spool	kg / pallet
1.2	22-30	150-300	D-200	5	900
1.2	22-30	150-300	BS-300	15	1080

REDRYING TEMPERATURE Not required

