

AA R5Y46

CATEGORY	FCAW Flux-Cored
TYPE	Rutile flux cored wire with slag support for M21 mixed gas with excellent welding properties in all positions.
APPLICATIONS	Offshore, Shipbuilding, pressure vessels, orbital pipe work.
PROPERTIES	Very good modeling ability, therefore excellent all-position welding with higher currents. Use up to -60 °C - 76 °F). Particularly suitable for MAG-orbital welding and for weldings on ceramics in all positions. Low spatter loss, and remarkable easy slag removal.

CLASSIFICATION	AWS	A 5.29: E81T1-K2M
	EN ISO	17632-A: T 46 6 1,5Ni P M 1 H5

SUITABLE FOR	Materials	DIN	EN	ASTM
	shipbuilding	A, B, D, E, AH 32 - EH 36	same	Typical
	Unalloyed steels	St 33, St 37-2 - St 52-3	S185 - S355-S460	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 480.7 TM	L210 - L480MB	A 299
	Fine grain steels	StE 255 to StE 460	S355-S420-S500 (NL1,2)	-
	API-standard	X 42, X65, X 70	X 42, X65, X 70	-

APPROVALS	TÜV, Lloyds (5Y46), DNV (5Y46), CE in progress.
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WELDING POSITIONS:



WELD METAL ANALYSIS % (TYPICAL VALUES M21)

C	Mn	Si	Cr	Ni	Mo	P	S
0.06	1.15	0.30	-	1.41	-	<0.009	<0.007

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	>460	530-680	>20		>60	>47	

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A) DC+	type spool / drum	kg / spool / drum	kg / pallet
1,2	21-33	150-300	D-200 / K-300 / Drum	5 / 15 / 250	1000 / 1024 / 500

REDRYING TEMPERATURE	NA
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GAS ACC. EN ISO 14175:	M21
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