



CEWELD AA R610

TYPE	Seamless micro alloyed rutile cored wire with slag for M21								
APPLICATIONS	Offshore, Shipbuilding, pressure vessels, orbital pipe work respecting the NACE requirements. Steels with yield strength up to 620 MPa (90 ksi).								
PROPERTIES	Very good modeling ability, therefore excellent all-position welding with higher currents. For use down to -40 °C (- 40 °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: E101T1-K2M H4							
	EN ISO	18276-A: T 62 4 Mn1Ni P M21 1 H5							
	F-nr	6							
	FM	2							
SUITABLE FOR	Reh ≤ 620 MPa ISO 15608: ~3.1, 2.2 1.8864, 1.8873, 1.8881, 1.8928, 1.8977, 1.8924, 1.8909, 1.8984, 1.8926, 1.8904, 1.8986 S500Q-S620Q, S500QL-S620QL, L485MB-L555MB, L485QB-L555QB, 620 M, PAS 460-550 ASTM A 572 Gr. 65; A 633 Gr. E; A 738 Gr. A; A 852; API 5 L X70, X80, X70Q, X80Q alform 500 M, 550 M, 600 M, aldur 550 Q, Dillimax 550, Dillimax 500, Domex 500, Domex 550								
APPROVALS	CE								
WELDING POSITIONS	      								
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S	Cr	Ni	Mo	Cu
	0.062	0.55	1.6	0.006	0.014	0.02	0.98	0.012	0.07
MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness	
					-40°C				
	As Welded	635	715	28	105			HRc	
REDRYING	Not required								
GAS ACC. EN ISO 14175	M21								



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AA R610 1,2MM

Packaging	KG/unit	EanCode
D-200	20 (4x5)	8720663423702
K-300	16	8720663423719