CEWELD AA B350

certilas® THE FILLER METAL SPECIALIST

TYPE	Seamless high basic flux core wire for Ar-CO2 mix
APPLICATIONS	Pipe work, shipbuilding, steel and vessel construction, mechanical engineering.
PROPERTIES	Extremely crack resistant weld metal conditioned by the basic slag. Low spatter loss, easy slag removal. Well suited for joining high carbon steels and when welding critical mixed base metal combinations. Ideal metallurgical choice for repair welding and production as well as for use as a buffer layer. Developed for repair welding of pipes using half shells

CLASSIFICATION

AWS	A 5.20: E61T-G
EN ISO	17632-A: T 35 4 B M 1 H5
F-nr	6
FM	1

SUITABLE FOR

Reh ≤ 350 MPa ISO 15608: 1.1, 1.2
1.0033. 1.0035, 1.0340, 1.0112, ...1.0426, 1.0473...1.0570
E155, S185, S235..S355, P235... P355
ASTM A284 Gr. C, D, A 830 M, A 516 M, A 299 M, A 573 M
UNS G10220, SAE 1022
Armco Steels, Telar 75

APPROVALS: CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S
0.04	0.6	1.2	0.015	0.015

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				-20°C	-40°C	
As Welded	350	500	27	100	80	HRc

REDRYING: Not required

GAS ACC. EN ISO 14175: M21