CEWELD AA M550SR

certilas® THE FILLER METAL SPECIALIST

TYPE	Seamless metal cored wire without slag for M21
APPLICATIONS	Crane, steel, vessel and apparatus construction, offshore, lifting, drilling platforms etc.
PROPRIÉTÉS	Seamless metal cored wire with remarkable stable arc and no spatters. Excellent for use in automated welding applications such as orbital Mag or robotic welding. This wire offers a unique welding deposit with less than 1% nickel to full fill NACE requirements and cover more procedures up to 500 MPa yield strength steels. CEWELD AA M500 can also be used for constructions that needs post weld heat treatment after welding and still offers mechanical properties confirming 5Y46 class. Due to the seamless production process the hydrogen content is below 3ml/100gr weld metal even after long storage in unconditioned condition.

CLASSIFICATION

AWS	A 5.36: E91T15-M21P4-K1-H4
EN ISO	18276-A: T 55 6 1NiMo M M21 1 H5
F-nr	6
FM	2

CONVIENT POUR

Reh ≤ 550 MPa ISO 15608: 1.2 (275 < ReH < 360 MPa), 1.3 (ReH > 360 MPa < 550 MPa)
1.8900, 1.8901, 1.8902, 1.8903, 1.8905, 1.8907, 1.8910, 1.8912, 1.8915, 1.8917, 1.8930, 1.8932, 1.8935, 1.8937, 1.8970, 1.8971, 1.8972, 1.8973, 1.8975
S460N, S420N, S460NL, P460N, StE 420, StE 460, StE 500, StE 550 TStE 380, S420NL, P460NL1, P420NH, P460NH, TStE 420, TStE 460, TStE 500,TStE 550 WStE 380, WStE 420, WStE 460, WStE 500, WstE 550, StE 385.7, StE 385.7 TM, StE 415, L485ME
ASTM A 203 Gr. D, E; A 350 Gr. LF1, LF2, LF3; A 420 Gr. WPL3, WPL6; A 516 Gr. 60, 65, 70; A 572 Gr. 42, 50, 55, 60, 65; A 633 Gr. A, D, E; A 662 Gr. A, B, C; A 707 Gr. L1, L2, L3; A 738 Gr. A; A 841 A, B, C; API 5 L X52, X60, X65, X52Q, X60Q, X65Q
Oceanfit 52, Oceanfit 60, Oceanfit 65, Oceanfit 355, Oceanfit 420, Oceanfit 460, PAS 460-550, alform® 500 M, 550 M, aldur 500 Q, 500 QL, aldur 550 Q, 550 QL

AGRÉMENTS: CE

POSITIONS DE SOUDAGE

ANALYSE CHIMIQUE TYPIQUE DU MÉTAL DE SOUDURE (%)

C	Si	Mn	P	S	Ni	Mo
0.05	0.5	1.3	0.015	0.015	0.9	0.35

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V -60°C	Hardness
As Welded	600	740	20	60	HRc
580°C±15°C 2h	580	640	25	50	HRc

ETUVAGE: Not required

GAS ACC. EN ISO 14175: M21