CEWELD AA R500

certilas® THE FILLER METAL SPECIALIST

TYPE

Seamless rutile flux cored 1% Nickel wire for FCAW welding S460 and X70 steel grades. (Type E 81-T1, T 50 6))

APPLICATIONS

Offshore, Shipbuilding, pressure vessels, orbital pipe work.

PROPERTIES

CEWELD® AA R500 is a seamless rutile cored wire that offers excellent modelling ability, therefore excelently suitable for position welding at high currents. The weld deposit shows reliable impact properties down to -60°C. Particularly suitable for MAG orbital welding and for welding on ceramics in all positions. CTOD tested at -20°C. Extremely low diffusible hydrogen content (on average below 3ml/100g).

CLASSIFICATION

AWS	A 5.29: E81T1-Ni1M-J H4
EN ISO	17632-A: T 50 6 1Ni P M21 1 H5
F-nr	6
FM	1

SUITABLE FOR

ReH ≤ 500 MPa ISO 15608: 1.1, 1.3, 2.1, 2.2 (ReH max. 500 MPa), 3.1 (ReH max. 500 MPa)
1.0580 to 1.0070, 1.8900 to 1.8905, 1.8930 to 1.8935, 1.8910 to 1.8915, 1.6217, 1.6210, 1.0481, 1.0482, 1.0551, 1.0553.
S275N-S460N, S275NL-S460NL, S275M-S460M, S275ML-S460ML, P355N, P355NH, P460N, P460NH, P275NL1-P460NL1, P275NL2- P460NL2, L360NB, L415NB, L360MB-L450MB, L360QB-L450QB
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, X70Q
Oceanfit 52, Oceanfit 60, Oceanfit 65, Oceanfit 355, Oceanfit 420, Oceanfit 460, alform plate 460M; durostat 400, 450, 500, durostat B2, aldur 500Q, aldur 500QL, aldur 500QL1, N-A-XTRA 56

APPROVALS

TÜV: 12705, CE, Lloyds, DNV

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Ni
0.08	0.5	1.4	0.015	0.015	0.9

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				-60°C	-40°C	
As Welded	550	600	24	80	90	HRc

REDRYING

Not required

GAS ACC. EN ISO 14175

M21, C1

CEWELD AA R500

AA R500 1,2MM

Packaging	KG/unit	EanCode
BS-300	16	8720663423672
D-200	20 (4x5)	8720663423658
Drum	250	8720663423665