



# 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 (%)**

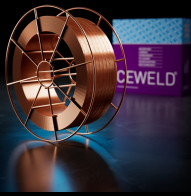
C	Si	Mn	P	S	Cr	Ni	Mo	Cu
0.062	0.55	1.6	0.006	0.014	0.02	0.98	0.012	0.07

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>P0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	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