



CEWELD AA B500

TYPE	Basic seamless micro alloyed flux cored welding wire																											
APPLICATIONS	Pressure vessels, steam boilers, riser pipes, low temperature requirements, high demanding and stressed constructions that needs post weld heat treatment.																											
PROPERTIES	AA B500 is a seamless high basic flux cored wire for extreme offshore requirements at sub zero temperatures down to - 60 °C (-80°C). Excellent welding properties. Therefore, suitable for the economic processing of high-strength, low temperature fine-grained structural steels with Rp0,2 > 500 MPa. Low hydrogen content HD< 3 ml/100g even after long storage.																											
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.29: E80T5-Ni</td> </tr> <tr> <td>EN ISO</td> <td>17632-A: T 50 6 1 Ni B M21 3 H5</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>1</td> </tr> </table>	AWS	A 5.29: E80T5-Ni	EN ISO	17632-A: T 50 6 1 Ni B M21 3 H5	F-nr	6	FM	1																			
AWS	A 5.29: E80T5-Ni																											
EN ISO	17632-A: T 50 6 1 Ni B M21 3 H5																											
F-nr	6																											
FM	1																											
SUITABLE FOR	<p>Reh ≤ 500 MPa, ISO 15608: 1.3, 2.1, 2.3</p> <p>S355JR, S355J0, S355J2, S450J0, S355N-S460N, S355NL-S460NL, S355M-S460M, S355ML-S460ML, S460Q, S500Q, S460QL, S500QL, S460QL1, S500QL1, P355GH, P355NH, P420NH, P460NH, P355N-P460N, P355NH-P460NH, P355NL1-P460NL1, P355NL2- P460NL2, L245NB- L415NB, L245MB-L485MB, L360QB-L485QB</p> <p>ASTM A 350 Gr. LF2; A 516 Gr. 65, 70; A 572 Gr. 42, 50, 60, 65; A 573 Gr. 70; A 588 Gr. B, C, K; A 633 Gr. A, C, D, E; A 662 Gr. B, C; A 678 Gr. B; A 707 Gr. L2, L3; A 841 Gr. A, B, C;</p> <p>API 5 L X42, X52, X60, X65, X70, X52Q, X60Q, X65Q, X70Q, aldur 500Q, aldur 500QL, aldur 500QL1, Domex 420 -500 MC,MC Plus, ML, Dilimax 460 -500,</p>																											
APPROVALS	CE																											
WELDING POSITIONS																												
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td style="width: 16.6%;">C</td> <td style="width: 16.6%;">Si</td> <td style="width: 16.6%;">Mn</td> <td style="width: 16.6%;">P</td> <td style="width: 16.6%;">S</td> <td style="width: 16.6%;">Ni</td> </tr> <tr> <td>0.08</td> <td>0.7</td> <td>1.5</td> <td>0.015</td> <td>0.015</td> <td>0.9</td> </tr> </table>	C	Si	Mn	P	S	Ni	0.08	0.7	1.5	0.015	0.015	0.9															
C	Si	Mn	P	S	Ni																							
0.08	0.7	1.5	0.015	0.015	0.9																							
MECHANICAL PROPERTIES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">Rp0,2 (MPa)</th> <th rowspan="2">Rm (MPa)</th> <th rowspan="2">A5 (%)</th> <th colspan="3">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th>-80°C</th> <th>-40°C</th> <th>-60°C</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>540</td> <td>620</td> <td>23</td> <td>50</td> <td colspan="2">HRc</td> <td></td> </tr> <tr> <td>570°C- 620°C 1h</td> <td>560</td> <td>645</td> <td>26</td> <td>120</td> <td>95</td> <td>70</td> <td>HRc</td> </tr> </tbody> </table>	Heat Treatment	Rp0,2 (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V			Hardness	-80°C	-40°C	-60°C	As Welded	540	620	23	50	HRc			570°C- 620°C 1h	560	645	26	120	95	70	HRc
Heat Treatment	Rp0,2 (MPa)					Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V			Hardness																	
		-80°C	-40°C	-60°C																								
As Welded	540	620	23	50	HRc																							
570°C- 620°C 1h	560	645	26	120	95	70	HRc																					
REDRYING	Not required																											
GAS ACC. EN ISO 14175	M21																											



CEWELD AA B500

AA B500 1,2MM

Packaging	KG/unit	EanCode
K-300	16	8720663405371