



CEWELD AA M550

| TYPE | Gas shielded seamless metal-cored wire 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 more than 2% nickel to offer reliable impact properties down to -60°C. CEWELD AA M550 is used for welding 550 MPa yield strength steels, due to the seamless production process the hydrogen content is below 3ml/100gr weld metal even after long storage in unconditioned condition. | | | | | | | | | | | | | | | | |
| CLASSIFICATION | <table border="0"> <tr> <td>AWS</td> <td>A 5.36: E91T15-M21A8-K7-H4</td> </tr> <tr> <td>EN ISO</td> <td>18276-A: T 55 6 Mn2,5Ni M M21 1 H5</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>2</td> </tr> </table> | AWS | A 5.36: E91T15-M21A8-K7-H4 | EN ISO | 18276-A: T 55 6 Mn2,5Ni M M21 1 H5 | F-nr | 6 | FM | 2 | | | | | | | | |
| AWS | A 5.36: E91T15-M21A8-K7-H4 | | | | | | | | | | | | | | | | |
| EN ISO | 18276-A: T 55 6 Mn2,5Ni M M21 1 H5 | | | | | | | | | | | | | | | | |
| F-nr | 6 | | | | | | | | | | | | | | | | |
| FM | 2 | | | | | | | | | | | | | | | | |
| CONVIENT POUR | Reh ≤ 550 MPa ISO 15608: 1.3, ~3.1, ~2.2, 2.1, 1.6780 ESTe 550, S550QL HY 80 15NiCrMo10-6 API 5 L X52, X60, X65, X52Q, X60Q, X65Q, X80 | | | | | | | | | | | | | | | | |
| AGRÉMENTS | CE | | | | | | | | | | | | | | | | |
| POSITIONS DE SOUDAGE | | | | | | | | | | | | | | | | | |
| TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%) | <table border="1" style="width: 100%; text-align: center;"> <tr> <td>C</td> <td>Si</td> <td>Mn</td> <td>P</td> <td>S</td> <td>Ni</td> </tr> <tr> <td>0.05</td> <td>0.7</td> <td>1.3</td> <td>0.015</td> <td>0.015</td> <td>2.2</td> </tr> </table> | C | Si | Mn | P | S | Ni | 0.05 | 0.7 | 1.3 | 0.015 | 0.015 | 2.2 | | | | |
| C | Si | Mn | P | S | Ni | | | | | | | | | | | | |
| 0.05 | 0.7 | 1.3 | 0.015 | 0.015 | 2.2 | | | | | | | | | | | | |
| PROPRIÉTÉS MÉCANIQUES | <table border="1" style="width: 100%; text-align: center;"> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R_{P0,2} (MPa)</th> <th rowspan="2">R_m (MPa)</th> <th rowspan="2">A₅ (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th>-40°C</th> <th>-60°C</th> </tr> <tr> <td>As Welded</td> <td>600</td> <td>740</td> <td>22</td> <td>75</td> <td>70</td> <td>HRc</td> </tr> </table> | Heat Treatment | R _{P0,2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | | Hardness | -40°C | -60°C | As Welded | 600 | 740 | 22 | 75 | 70 | HRc |
| Heat Treatment | R _{P0,2} (MPa) | | | | | R _m (MPa) | A ₅ (%) | | Impact Energy (J) ISO-V | | Hardness | | | | | | |
| | | -40°C | -60°C | | | | | | | | | | | | | | |
| As Welded | 600 | 740 | 22 | 75 | 70 | HRc | | | | | | | | | | | |
| ETUVAGE | Not required | | | | | | | | | | | | | | | | |
| GAS ACC. EN ISO 14175 | M21 | | | | | | | | | | | | | | | | |



CEWELD AA M550

AA M550 1,2MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| K-300 | 16 | 8720663405418 |