CEWELD® AA R690

CATEGORY	FCAW Flux-Cored
TYPE	Seamless rutile flux-cored welding wire for high strength S690-HY100 steels
APPLICATIONS	Shipbuilding, steel and vessel construction, mechanical engineering and pipe work, offshore, crane building, lifting, platforms. Steels with yield strength up to 690 MPa (100 ksi).
PROPERTIES	CEWELD® AA R690 was one of "The first seamless rutile FCW with extreme low hydrogen for S690" Excellent for use in positional welding where high deposition rate is required, suitable for temperatures down to -60 ºC (with offshore Approval down to -40°C). Excellent for use on ceramic backing and Mag orbital welding in all positions. Extreme low spatter properties and excellent arc stability with fast freezing slag.

CLASSIFICATION

AWS	A 5.29: E111T1-K4M H4
AWS	A 5.36: E111T1-M21A4-G-H4
EN ISO	18276-A: T 69 6 Z P M21 1 H5
F-nr	6
FM	2

SUITABLE FOR	StE690,7 TM, L690M, S690G1QL1, S690, Weldox 700, Naxtra 70, Dilimax, S550, S620, S620Ql1, S690QL1, S600MC, S700MC, Naxtra 63, Naxtra 70, Optim 700 mc plus, TStE620, TStE690, Weldox 500, Hardox, L480 - L550, X65, X80, X90, X100, Hardox 400, XAR 400, Dilidur 400, 20MnCr65, 28CrMn43, Domex, ASTM: A 517 Gr A - P A 572 Gr 65, Oceanfit 100, Oceanfit 690
APPROVALS	CE Lloyds DNV

WELDING POSITIONS:

TYPICAL WELD DEPOSIT WEIGHT %

C	Si	Mn	P	S	Cr	Ni	Mo
0.05	0.4	1.6	0.015	0.015	0.5	2.2	0.5

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Impact Energy (J) ISO-V -40°C	-60°C
As Welded /	705	850	20	75	50

WELDING PARAMETERS / PACKING

WELDING PARAMETERS	WELDING PARAMETERS	WELDING PARAMETERS	PACKING	PACKING	PACKING
D (MM)	VOLTAGE (V)	CURRENT (A)	SPOOLING TYPE	KG / SPOOL / DRUM	KG / PALLET
1,0	19-25	140-230	D-200 / K-300 / DRUM	5 / 16 / 300	1000 / 1024 / 600
1.2	23-32	190-350	D-200 / K-300 / DRUM	5 / 16 / 300	1000 / 1024 / 600

REDRYING TEMPERATURE	Not required
GAS ACCORDING EN 14175	M21