certilas® THE FILLER METAL SPECIALIST

CEWELD AA R500 PIPE

TYPE

Seamless rutile flux cored wire with < 1% Ni, for FCAW orbital welding (H2-Ready) S480 and X80 steel grades. (Type E 81-T1, T 50 4)

APPLICATIONS

CEWELD® AA R500 PIPE is a seamless rutile cored wire with very good modelling properties that is ideal for constrained position welding with higher amperages. Particularly suitable for orbital welding and generally for welding on weld pool protection in all positions, even with high heat input. CEWELD® AA R500 PIPE is suitable for the following applications: Pipeline and tank construction (H2-Ready), steel and shipbuilding as well as offshore and onshore applications.

PROPERTIES

CEWELD® AA R500 PIPE is ideal for welding in all positions with higher currents. Can be used down to -40°C (-60°C). It has low spatter losses and remarkably easy slag removal. Due to the seamless manufacturing process, the content of diffusible hydrogen in the weld metal is extremely low (on average less than 3 ml/100 g). For the entire storage and processing time, < 4 ml/100 g is guaranteed according to AWS.
EN -ISO 17632-A: T 50 4 Mn1Ni P M21 1 H5 (for > 1.5 kJ/mm) EN -ISO 18276-A: T 55 4 Mn1Ni P M21 1 H5 (for < 1.5 kJ/mm) ASME -AWS A 5. 36: E81T1-M21A4-Ni1-H4 (for > 1.5 kJ/mm) ASME -AWS A 5.36: E91T1-M21A4-Ni1-H4 (for < 1.5 kJ/mm)

CLASSIFICATION

AWS	A 5.36: E81T1-M21A8-Ni1-H4
AWS	A 5.36: E91T1-M21A8-Ni1-H4
EN ISO	17632-A: T 50 4 Mn1Ni P M21 1 H5
EN ISO	18276-A: T 55 4 Mn1Ni 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

CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Ni
0.08	0.5	1.5	0.015	0.015	0.9

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Impact Energy (J) ISO-V -40°C
As Welded /	575	644	26	90

REDRYING TEMPERATURE

Not required

GAS ACCORDING EN 14175

M21

CEWELD AA R500 PIPE

AA R500 PIPE 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663423689
D-200	5	8720663400055