










CEWELD AA M550

TYPE	Gas shielded seamless metal-cored wire for M21.(Typ T 55 6 Mn2,5Ni, E91T15)					
APPLICATIONS	CEWELD®AA M550 is used for welding steels up to a yield strength of 550 MPa. The areas of application are in: Crane, steel, ship (submarine) and apparatus construction, offshore, hoists, drilling rigs, etc.					
PROPERTIES	CEWELD®AA M550 is a seamless metal flux cored wire with remarkable arc stability and virtually no spatter. Excellent for automated welding applications such as orbital mag or robotic welding. This wire offers a unique weld metal with more than 2 % nickel, which ensures reliable impact strength down to -60 °C. Due to the continuous production process, the hydrogen content is below 3 ml/100 g of weld metal even after long storage in an unconditioned state.					
CLASSIFICATION	AWS	A 5.36: E91T15-M21A8-K7-H4				
	EN ISO	18276-A: T 55 6 Mn2,5Ni M M21 1 H5				
	EN ISO	18276-A: T 55 6 1NiMo M M21 1 H5				
	F-nr	6				
	FM	2				
SUITABLE FOR	Reh ≤ 550 MPa ISO 15608: 1.3, ~3.1, ~2.2, 2.1, 1.6780 EStE 550, S550QL HY 80 15NiCrMo10-6, G19NiCrMo 12-6 A 543M, A 537M API 5 L X52, X60, X65, X52Q, X60Q, X65Q, X80					
APPROVALS	CE					
WELDING POSITIONS	      					
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S	Ni
	0.05	0.7	1.3	0.015	0.015	2.2
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} MPa	R _m MPa	A5 (%)	Impact Energy (J) ISO-V	
	As Welded /	600	740	22	-40°C 75	-60°C 70
REDRYING TEMPERATURE	Not required					
GAS ACCORDING EN 14175	M21					



CEWELD AA M550

AA M550 1,2MM

Type	KG/unit	EANCode
K-300	16	8720663405418