



# 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	<table><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>EN ISO</td><td>18276-A: T 55 6 1NiMo 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	EN ISO	18276-A: T 55 6 1NiMo M M21 1 H5	F-nr	6	FM	2					
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SUITABLE FOR	<p><b>Reh ≤ 550 MPa ISO 15608: 1.3, ~3.1, ~2.2, 2.1,</b> 1.6780 EStE 550, S550QL <b>HY 80</b> 15NiCrMo10-6, G19NiCrMo 12-6 A 543M, A 537M API 5 L X52, X60, X65, X52Q, X60Q, X65Q, X80</p>																					
APPROVALS	CE																					
WELDING POSITIONS																						
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table><tr><td>C</td><td>0.05</td><td>Si</td><td>0.7</td><td>Mn</td><td>1.3</td><td>P</td><td>0.015</td><td>S</td><td>0.015</td><td>Ni</td><td>2.2</td></tr></table>							C	0.05	Si	0.7	Mn	1.3	P	0.015	S	0.015	Ni	2.2			
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ALL WELD MECHANICAL PROPERTIES	<table><thead><tr><th>Heat Treatment</th><th>R<sub>P0,2</sub> MPa</th><th>Rm MPa</th><th>A5 (%)</th><th colspan="3">Impact Energy (J) ISO-V</th></tr></thead><tbody><tr><td>As Welded /</td><td>600</td><td>740</td><td>22</td><td>-40°C</td><td>75</td><td>-60°C</td><td>70</td></tr></tbody></table>							Heat Treatment	R <sub>P0,2</sub> MPa	Rm MPa	A5 (%)	Impact Energy (J) ISO-V			As Welded /	600	740	22	-40°C	75	-60°C	70
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As Welded /	600	740	22	-40°C	75	-60°C	70															
REDRYING TEMPERATURE	Not required																					
GAS ACCORDING EN 14175	M21																					



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AA M550 1,2MM

Type	KG/unit	EANCode
K-300	16	8720663405418