



# CEWELD AA M500

**TYPE** Seamless metal cored wire without slag for M21. (E80C-Ni1, T 50 6 .. Ni1)

**APPLICATIONS** CEWELD® AA M500 meets the latest offshore requirements for sub-zero temperatures down to -60°C. The wire is suitable for steel grades up to 500 MPa yield strength (such as S500). In the areas of: Cranes, heavy transport, platforms, ships and lifting equipment in the offshore sector, pipelines and applications that must fulfil NACE requirements (less than 1% nickel).

**PROPERTIES** CEWELD® AA M500 is a unique filler metal with less than 1% nickel that fully complies with NACE requirements and covers a wider range of applications up to steels with a yield strength of 500 MPa. CEWELD® AA M500 can also be used for constructions requiring post-weld heat treatment and still provide mechanical properties confirming class 5Y46. Due to the seamless manufacturing process, the hydrogen content is below 3 ml/100 g of weld metal even after prolonged storage in the unconditioned state.

**CLASSIFICATION**

AWS	A 5.28: E80C-Ni1 H4
AWS	A 5.36: E81T15-M21A8-Ni1-H4
EN ISO	17632-A: T 50 6 1Ni M M21 1 H5
F-nr	6
FM	1

**SUITABLE FOR** **Reh ≤ 500 MPa ISO 15608: 1.3, ~3.1, ~2.2, 2.1,**  
 1.8900, 1.8901, 1.8902, 1.8903, 1.8905, 1.8907, 1.8910, 1.8912, 1.8915, 1.8917, 1.8930, 1.8932, 1.8935, 1.8937, 1.8970, 1.8971, 1.8972, 1.8973, 1.8975  
 S460N, S420N, S460NL, P460N, StE 420, StE 460, StE 500, TStE 380, S420NL, P460NL1, P420NH, P460NH, TStE 420, TStE 460, TStE 500, WStE 380, WStE 420, WStE 460, WStE 500, StE 385.7, StE 385.7 TM, StE 415, L485ME  
 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  
 Oceanfit 52, Oceanfit 60, Oceanfit 65, Oceanfit 355, Oceanfit 420, Oceanfit 460, alform plate 460M; durostat 400, 450, 500, durostat B2

**APPROVALS** CE DNV

**WELDING POSITIONS**

**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

C	Si	Mn	P	S	Ni
0.05	0.7	1.5	0.015	0.015	0.9

**ALL WELD MECHANICAL PROPERTIES**

Heat Treatment	R <sub>P0.2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)	Impact Energy (J) ISO-V	
				-40°C	-60°C
As Welded /	550	690	26	80	60

**REDRYING TEMPERATURE** Not required

**GAS ACCORDING EN 14175** M21



# CEWELD AA M500

AA M500 1,2MM

Type	KG/unit	EANCode
BS-300	16	8720663423405