



CEWELD AA M500

TYPE Seamless metal cored wire for welding S460 - X70 type steels

APPLICATIONS Crane, steel, vessel and apparatus construction, offshore, lifting, drilling platforms etc.

PROPERTIES CEWELD® AA M500 is a seamless metal cored wire with remarkable stable arc and no spatters. Excellent for use in automated welding applications such as orbital Mag or robotic welding. This wire offers a unique welding deposit with less than 1% nickel to full fill NACE requirements and cover more procedures up to 500 MPa yield strength steels. CEWELD® AA M500 can also be used for constructions that needs post weld heat treatment after welding and still offers mechanical properties confirming 5Y46 class. Due to the seamless production process the hydrogen content is below 3ml/100gr weld metal even after long storage in unconditioned condition.

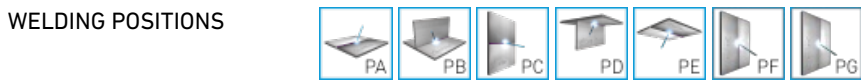
CLASSIFICATION

| | |
|--------|--------------------------------|
| 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,
 1.0580 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
 Oceanfit 52, Oceanfit 60, Oceanfit 65, Oceanfit 355, Oceanfit 420, Oceanfit 460, alform plate 460M; durostat 400, 450, 500, durostat B2

APPROVALS CE



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

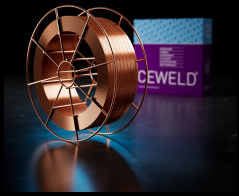
| C | Si | Mn | P | S | Ni |
|------|-----|-----|-------|-------|-----|
| 0.05 | 0.7 | 1.5 | 0.015 | 0.015 | 0.9 |

ALL WELD MECHANICAL PROPERTIES

| Heat Treatment | R _{P0,2} MPa | R _m MPa | A ₅ (%) | 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 |