CEWELD® AA M500

CATEGORY	FCAW Flux-Cored
TYPE	Seamless metal core wire without slag for M21
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

Materials	DIN	EN	ASTM
shipbuilding	A, B, D, E, AH 32 - EH 36	same	Typical
Unalloyed steels	St 33, St 37-2 - St 52-3	S185 - S355-S460-S485	A 258 / A 516
boiler steels	H I, H III, 17Mn4, 19Mn5	P235GH, P355GH	A 662 / A 387
pipe steels	St 35.8, St 45.8	P235T1/T2, P460NL2	A 738 / A 612
-	StE 210.7 TM, StE 480.7 TM	L210 - L480MB	A 299
Fine grain steels	StE 255 to StE 500	S255 - S500 (NL1,2)	-
API-standard	X 42, X65, X 70	X 42, X65, X 70	-

APPROVALS: CE

WELDING POSITIONS:

TYPICAL WELD DEPOSIT WEIGHT %

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	Rm MPa	A5 (%)	Impact Energy (J) ISO-V -40°C	-60°C
As Welded /	550	690	26	80	60

WELDING PARAMETERS / PACKING

WELDING PARAMETERS D (MM)	WELDING PARAMETERS VOLTAGE (V)	WELDING PARAMETERS CURRENT (A) DC+	PACKING SPOOL TYPE	PACKING KG / SPOOL / DRUM	PACKING KG / PALLET
1,0	14-26	70-230	D-200 / K-300 / DRUM	5 / 16 / 300	1000 / 1024 / 600
1,2	14-30	90-300	D-200 / K-300 / DRUM	5 / 16 / 300	1000 / 1024 / 600
1,6	17-34	120-380	D-200 / K-300 / DRUM	5 / 16 / 300	1000 / 1024 / 600

REDRYING TEMPERATURE: Not required

GAS ACCORDING EN 14175: M21