




CEWELD AA B550

TYPE	Basic seamless micro alloyed flux cored welding wire																				
APPLICATIONS	Vessel and apparatus construction, offshore, lifting, drilling platforms etc.																				
PROPERTIES	AA B550 is a seamless high basic flux cored wire for extreme requirements at sub zero temperatures down to -60 °C. Excellent welding properties. Yield strength < 600 MPa. Low hydrogen content HD< 3 ml/100g even after long storage.																				
CLASSIFICATION	AWS A 5.29: E80T5-K1M-J H4 AWS A 5.36: E80T5-M21A4-K1-H4 EN ISO 18276-A: T 55 6 1NiMo B M21 1 H5 F-nr 6 FM 2																				
SUITABLE FOR	Typical for: Reh ≤ 550 MPa ISO 15608: 1.2, 1.3, 2.1, 2.2, 3.1 1.8905 , 1.8907, 1.8937 , 1.8915, 1.8917, 1.8944 , 1.8954, 1.6780, 1.8817, 1.6368, 1.8807 15NiCuMoNb5, 17MnMoV53, WB36, 20MnMoNi4-5, WB35, BHW 35 , BHW 38, X42, X60, X80 StE 460, StE 500, WStE 500 , TStE 460, TStE 500, NAXTRA 56 , NAXTRA 63																				
APPROVALS	No Approvals Found																				
WELDING POSITIONS																					
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Ni</th> <th>Mo</th> </tr> </thead> <tbody> <tr> <td>0.05</td> <td>0.4</td> <td>1.2</td> <td>0.015</td> <td>0.015</td> <td>1</td> <td>0.3</td> </tr> </tbody> </table>	C	Si	Mn	P	S	Ni	Mo	0.05	0.4	1.2	0.015	0.015	1	0.3						
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ALL WELD MECHANICAL PROPERTIES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R_{p0,2} MPa</th> <th rowspan="2">R_m MPa</th> <th rowspan="2">A₅ (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> </tr> <tr> <th>-60°C</th> <th>-40°C</th> </tr> </thead> <tbody> <tr> <td>As Welded /1h</td> <td>580</td> <td>720</td> <td>20</td> <td>80</td> <td>100</td> </tr> <tr> <td>570°C- 620°C /1h</td> <td>680</td> <td>550</td> <td>25</td> <td>50</td> <td>65</td> </tr> </tbody> </table>	Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V		-60°C	-40°C	As Welded /1h	580	720	20	80	100	570°C- 620°C /1h	680	550	25	50	65
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GAS ACCORDING EN 14175	M21																				