








CEWELD AA R500SR

TYPE	Seamless copper coated rutile flux-cored wire for M21. (Type E 81 T1, T 50 6)					
APPLICATIONS	<p>CEWELD® AA R500 SR is a seamless rutile cored wire that is characterised by its excellent modelling properties. This means that constrained position welding is also possible in all positions. It is particularly suitable for welding on ceramics in all positions, with low spatter losses and easily removable slag.</p> <p>The main areas of application for CEWELD AA R500 SR include: Crane construction, heavy machinery, platforms, ships and lifting equipment in the offshore sector, pipelines and applications that must comply with NACE requirements (less than 1 % nickel) and PWHT is required.</p>					
PROPERTIES	<p>CEWELD® AA R500 SR is characterised by its outstanding quality properties. Outstanding notched bar impact values are achieved at temperatures down to -60 °C and the PWHT results are also of the highest quality. It is particularly suitable for welding on ceramics in all positions. Low spatter losses and easily removable slag also characterise this cored wire.</p>					
CLASSIFICATION	AWS	A 5.29: E81T1-Ni1M-J H4				
	AWS	A 5.36: E81T1-M21A8-Ni1-H4				
	EN ISO	17632-A: T 50 6 1Ni P M21 1 H5				
SUITABLE FOR	<p>ReH ≤ 500 MPa ISO 15608: 1.1, 1.3, 2.1, 2.2 (ReH max. 500 MPa), 3.1 (ReH max. 500 MPa)</p> <p>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.</p> <p>S275N-S460N, S275NL-S460NL, S275M-S460M, S275ML-S460ML, P355N, P355NH, P460N, P460NH, P275NL1-P460NL1, P275NL2- P460NL2, L360NB, L415NB, L360MB-L450MB, L360QB-L450QB</p> <p>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, X70Q</p> <p>Oceanfit 52, Oceanfit 60, Oceanfit 65, Oceanfit 355, Oceanfit 420, Oceanfit 460, alform plate 460M; durostat 400, 450, 500, durostat B2, aldur 500Q, aldur 500QL, aldur 500QL1, N-A-XTRA 56</p>					
APPROVALS	CE					
WELDING POSITIONS	<div></div>					
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S	Ni
	0.08	0.5	1.4	0.015	0.015	0.9
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} MPa	R _m MPa	A5 (%)	Impact Energy (J) ISO-V -60°C	
	As Welded /	550	600	22	70	
	570°C- 620°C /1h	520	580	22	50	
REDRYING TEMPERATURE	Not required					
GAS ACCORDING EN 14175	M21					



CEWELD AA R500SR

AA R500SR 1,2MM

Type	KG/unit	EANCode
BS-300	16	8720663424563