CEWELD AA R500

certilas® THE FILLER METAL SPECIALIST

TYPE

Seamless rutile flux cored 1% Nickel wire for FCAW welding S460 and X70 steel grades. (Type E 81-T1, T 50 6))

APPLICATIONS

CEWELD® AA R500 is a seamless rutile cored wire with remarkable arc stability and virtually no spatter. Excellent for use in automated welding applications such as orbital mag or with welding tractors. It fulfils the latest offshore requirements for ultra-low temperatures down to -60°C. The wire is suitable for steel grades with a yield strength of up to 500 MPa (e.g. S500). Areas of application: Cranes, heavy machinery, platforms, ships and lifting equipment in the offshore sector, pipelines and applications that must fulfil NACE requirements (less than 1% nickel).

PROPERTIES

CEWELD® AA R500 is a seamless rutile cored wire that offers excellent modelling ability, therefore excelently suitable for position welding at high currents. The weld deposit shows reliable impact properties down to -60°C. Particularly suitable for MAG orbital welding and for welding on ceramics in all positions. CTOD tested at -20°C. Extremely low diffusible hydrogen content (on average below 3ml/100g).

CLASSIFICATION

AWS	A 5.29: E81T1-Ni1M-J H4, A 5.36: E81T1-M21A8-Ni1-H4
EN ISO	17632-A: T 50 6 1Ni P M21 1 H5, 17632-A: T 46 4 1Ni P C1 1 H5
F-nr	6
FM	1

SUITABLE FOR

ReH ≤ 500 MPa ISO 15608: 1.1, 1.3, 2.1, 2.2 (ReH max. 500 MPa), 3.1 (ReH max. 500 MPa)
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, X70Q
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

APPROVALS

TÜV: (12705), CE, Lloyds, DNV

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Ni
0.08	0.5	1.4	0.015	0.015	0.9

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				-60°C	-40°C	
As Welded	550	600	24	80	90	HRc

REDRYING

Not required

GAS ACC. EN ISO 14175

M21, C1

CEWELD AA R500

AA R500 1,2MM

Packaging	KG/unit	EanCode
BS-300	16	8720663423672
D-200	20 (4x5)	8720663423658
Drum	250	8720663423665

AA R500 1,6MM

Packaging	KG/unit	EanCode
BS-300	16	8720682051627

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