



CEWELD AA B500

TYPE	Basic seamless micro alloyed flux cored welding wire							
ANWENDUNGEN	Pressure vessels, steam boilers, riser pipes, low temperature requirements, high demanding and stressed constructions that needs post weld heat treatment.							
EIGENSCHAFTEN	AA B500 is a seamless high basic flux cored wire for extreme offshore requirements at sub zero temperatures down to - 60 °C (-80°C). Excellent welding properties. Therefore, suitable for the economic processing of high-strength, low temperature fine-grained structural steels with Rp0,2 > 500 MPa. Low hydrogen content HD< 3 ml/100g even after long storage.							
KLASSIFIKATION	AWS	A 5.29: E80T5-Ni, A 5.36: E80T5-M21A8-Ni1-H4						
	EN ISO	17632-A: T 50 6 1 Ni B M21 3 H5						
	F-nr	6						
	FM	1						
GEEIGNET FÜR	Reh ≤ 500 MPa, ISO 15608: 1.3, 2.1, 2.3 S355JR, S355J0, S355J2, S450J0, S355N-S460N, S355NL-S460NL, S355M-S460M, S355ML-S460ML, S460Q, S500Q, S460QL, S500QL, S460QL1, S500QL1, P355GH, P355NH, P420NH, P460NH, P355N-P460N, P355NH-P460NH, P355NL1-P460NL1, P355NL2- P460NL2, L245NB- L415NB, L245MB-L485MB, L360QB-L485QB ASTM A 350 Gr. LF2; A 516 Gr. 65, 70; A 572 Gr. 42, 50, 60, 65; A 573 Gr. 70; A 588 Gr. B, C, K; A 633 Gr. A, C, D, E; A 662 Gr. B, C; A 678 Gr. B; A 707 Gr. L2, L3; A 841 Gr. A, B, C; API 5 L X42, X52, X60, X65, X70, X52Q, X60Q, X65Q, X70Q, aldur 500Q, aldur 500QL, aldur 500QL1, Domex 420 -500 MC,MC Plus, ML, Dilimax 460 -500,							
ZULASSUNGEN	CE							
SCHWEISSPOSITIONEN	   							
TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%)	C	Si	Mn	P	S	Ni		
	0.08	0.7	1.5	0.015	0.015	0.9		
MECHANISCHE GÜTEWERTE	Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness
	As Welded	540	620	23	-80°C	-40°C	-60°C	
	570°C- 620°C 1h	560	645	26	50	HRc	70	HRc
RÜCKTROCKNUNG	Not required							
GAS ACC. EN ISO 14175	M21							



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AA B500 1,2MM

Packaging	KG/unit	EanCode
K-300	16	8720663405371