



CEWELD AA B550

TYPE

ANWENDUNGEN

EIGENSCHAFTEN

KLASSIFIKATION

GEEIGNET FÜR

ZULASSUNGEN

SCHWEISSPOSITIONEN

TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%)

MECHANISCHE GÜTEWERTE

RÜCKTROCKNUNG

GAS ACC. EN ISO 14175

Basic seamless micro alloyed flux cored welding wire

Vessel and apparatus construction, offshore, lifting, drilling platforms etc.

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 > 550 MPa. Low hydrogen content HD< 3 ml/100g even after long storage.

AWS

EN ISO

F-nr

FM

A 5.29: E80T5-K1M-J H4, A 5.36: E80T5-M21A4-K1-H4

18276-A: T 55 6 1NiMo B M21 1 H5

6

2

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

PA

PB

PC

C	Si	Mn	P	S	Ni	Mo
0.05	0.4	1.2	0.015	0.015	1	0.3

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				-60°C	-40°C	
As Welded	580	720	20	80	100	HRc
570°C- 620°C 1h	680	550	25	65	50	HRc

Not required

M21