



# CEWELD AA R610

|                                             |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                  |                      |                    |                         |      |      |          |      |
|---------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------|----------------------|--------------------|-------------------------|------|------|----------|------|
| TYPE                                        | Seamless micro alloyed rutile cored wire with slag for M21                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                                  |                      |                    |                         |      |      |          |      |
| APPLICATIONS                                | Offshore, Shipbuilding, pressure vessels, orbital pipe work respecting the NACE requirements. Steels with yield strength up to 620 MPa (90 ksi).                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                  |                      |                    |                         |      |      |          |      |
| PROPERTIES                                  | Very good modeling ability, therefore excellent all-position welding with higher currents. For use down to -40 °C (- 40 °F) .. Particularly suitable for MAG-orbital welding and for weldings on ceramics in all positions. Low spatter loss, and remarkable easy slag removal.                                                                                                                                                                                                                                                                                                                                 |                                  |                      |                    |                         |      |      |          |      |
| CLASSIFICATION                              | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | A 5.29: E101T1-K2M H4            |                      |                    |                         |      |      |          |      |
|                                             | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | 18276-A: T 62 4 Mn1Ni P M21 1 H5 |                      |                    |                         |      |      |          |      |
|                                             | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | 6                                |                      |                    |                         |      |      |          |      |
|                                             | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | 2                                |                      |                    |                         |      |      |          |      |
| SUITABLE FOR                                | <b>Reh ≤ 620 MPa ISO 15608: ~3.1, 2.2</b><br>1.8864, 1.8873, 1.8881, 1.8928, 1.8977, 1.8924, 1.8909, 1.8984, 1.8926, 1.8904, 1.8986<br>S500Q-S620Q, S500QL-S620QL, L485MB-L555MB, L485QB-L555QB, 620 M, PAS 460-550<br>ASTM A 572 Gr. 65; A 633 Gr. E; A 738 Gr. A; A 852;<br>API 5 L X70, X80, X70Q, X80Q<br>alform 500 M, 550 M, 600 M, aldur 550 Q, Dillimax 550, Dillimax 500, Domex 500, Domex 550                                                                                                                                                                                                         |                                  |                      |                    |                         |      |      |          |      |
| APPROVALS                                   | CE                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                  |                      |                    |                         |      |      |          |      |
| WELDING POSITIONS                           | <div>      </div> |                                  |                      |                    |                         |      |      |          |      |
| TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | Si                               | Mn                   | P                  | S                       | Cr   | Ni   | Mo       | Cu   |
|                                             | 0.062                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | 0.55                             | 1.6                  | 0.006              | 0.014                   | 0.02 | 0.98 | 0.012    | 0.07 |
| MECHANICAL PROPERTIES                       | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | R <sub>P0,2</sub> (MPa)          | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |      |      | Hardness |      |
|                                             |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                  |                      |                    | -40°C                   |      |      |          |      |
|                                             | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | 635                              | 715                  | 28                 | 105                     |      |      | HRc      |      |
| REDRYING                                    | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |                                  |                      |                    |                         |      |      |          |      |
| GAS ACC. EN ISO 14175                       | M21                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                                  |                      |                    |                         |      |      |          |      |



# CEWELD AA R610

AA R610 1,2MM

| Packaging | KG/unit  | EanCode       |
|-----------|----------|---------------|
| D-200     | 20 (4x5) | 8720663423702 |
| K-300     | 16       | 8720663423719 |