



# CEWELD AA M550SR

**TYPE** Seamless, Nickel-Molybdenum alloyed, metalcored wire. ( Type T55 6 1NiMo, E 91T)

**APPLICATIONS** CEWELD® AA M500 offers a unique weld metal with less than 1% nickel, even after PWHT, for steels up to 550 MPa yield strength.  
Areas of application are:  
Crane, steel, ship and apparatus construction, offshore, hoists, drilling rigs, etc.

**PROPERTIES** CEWELD® AA M500 has a remarkably stable and spatter-free arc. Excellent for automated welding applications such as orbital mag or robotic welding. This wire offers a unique weld metal with less than 1% nickel that fully complies with NACE requirements and covers multiple processes up to a yield strength of 500 MPa. CEWELD AA M500 can also be used for constructions that require post-weld heat treatment and still provide mechanical properties equivalent to class 5Y46. Due to the continuous manufacturing process, the hydrogen content is less than 3 ml/100 g of weld metal even after prolonged storage in unconditioned condition.

**CLASSIFICATION**

AWS	A 5.36: E91T15-M21P4-K1-H4
EN ISO	18276-A: T 55 6 1NiMo M M21 1 H5
F-nr	6
FM	2

**SUITABLE FOR** **ReH ≤ 550 MPa ISO 15608: 1.2 (275 < ReH < 360 MPa), 1.3 (ReH > 360 MPa < 550 MPa)**  
 1.8900, 1.8901, 1.8902, 1.8903, 1.8905, 1.8907, 1.8910, 1.8912, 1.8915, 1.8917, 1.8930, 1.8932, 1.8935, 1.8937, 1.8970, 1.8971, 1.8972, 1.8973, 1.8975  
 S460N, S420N, S460NL, P460N, StE 420, StE 460, StE 500, StE 550 TStE 380, S420NL, P460NL1, P420NH, P460NH, TStE 420, TStE 460, TStE 500, TStE 550 WStE 380, WStE 420, WStE 460, WStE 500, WstE 550, StE 385.7, StE 385.7 TM, StE 415, L485ME  
 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  
 Oceanfit 52, Oceanfit 60, Oceanfit 65, Oceanfit 355, Oceanfit 420, Oceanfit 460, PAS 460-550, alform® 500 M, 550 M, aldur 500 Q, 500 QL, aldur 550 Q, 550 QL

**APPROVALS** CE

**WELDING POSITIONS**

**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

C	Si	Mn	P	S	Ni	Mo
0.05	0.5	1.3	0.015	0.015	0.9	0.35

**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
				-60°C	
As Welded	600	740	20	60	HRc
580°C±15°C 2h	580	640	25	50	HRc

**REDRYING** Not required

**GAS ACC. EN ISO 14175** M21