








CEWELD AA M550

| TYPE | Gas shielded seamless metal-cored wire for M21.(Typ T 55 6 Mn2,5Ni, E91T15) | | | | | | | | | | | | | | | | |
|---|--|----------------|-------------------------|----------------------|--------------------|-------------------------|--------------------|----------|-------------------------|-------|-----------|-------|-----|----|----|----|-----|
| APPLICATIONS | CEWELD®AA M550 is used for welding steels up to a yield strength of 550 MPa. The areas of application are in: Crane, steel, ship (submarine) and apparatus construction, offshore, hoists, drilling rigs, etc. | | | | | | | | | | | | | | | | |
| PROPERTIES | CEWELD®AA M550 is a seamless metal flux cored wire with remarkable arc stability and virtually no spatter. Excellent for automated welding applications such as orbital mag or robotic welding. This wire offers a unique weld metal with more than 2 % nickel, which ensures reliable impact strength down to -60 °C. Due to the continuous production process, the hydrogen content is below 3 ml/100 g of weld metal even after long storage in an unconditioned state. | | | | | | | | | | | | | | | | |
| CLASSIFICATION | AWS A 5.36: E91T15-M21A8-K7-H4 EN ISO 18276-A: T 55 6 Mn2,5Ni M M21 1 H5, 18276-A: T 55 6 1NiMo M M21 1 H5 F-nr 6 FM 2 | | | | | | | | | | | | | | | | |
| SUITABLE FOR | Reh ≤ 550 MPa ISO 15608: 1.3, ~3.1, ~2.2, 2.1, 1.6780 EStE 550, S550QL HY 80 15NiCrMo10-6, G19NiCrMo 12-6 A 543M, A 537M API 5 L X52, X60, X65, X52Q, X60Q, X65Q, X80 | | | | | | | | | | | | | | | | |
| APPROVALS | CE | | | | | | | | | | | | | | | | |
| WELDING POSITIONS | <div>      </div> | | | | | | | | | | | | | | | | |
| TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%) | <table><tr><td>C</td><td>Si</td><td>Mn</td><td>P</td><td>S</td><td>Ni</td></tr><tr><td>0.05</td><td>0.7</td><td>1.3</td><td>0.015</td><td>0.015</td><td>2.2</td></tr></table> | C | Si | Mn | P | S | Ni | 0.05 | 0.7 | 1.3 | 0.015 | 0.015 | 2.2 | | | | |
| C | Si | Mn | P | S | Ni | | | | | | | | | | | | |
| 0.05 | 0.7 | 1.3 | 0.015 | 0.015 | 2.2 | | | | | | | | | | | | |
| MECHANICAL PROPERTIES | <table><tr><th rowspan="2">Heat Treatment</th><th rowspan="2">R_{p0,2} (MPa)</th><th rowspan="2">R_m (MPa)</th><th rowspan="2">A₅ (%)</th><th colspan="2">Impact Energy (J) ISO-V</th><th rowspan="2">Hardness</th></tr><tr><th>-40°C</th><th>-60°C</th></tr><tr><td>As Welded</td><td>600</td><td>740</td><td>22</td><td>75</td><td>70</td><td>HRc</td></tr></table> | Heat Treatment | R _{p0,2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | | Hardness | -40°C | -60°C | As Welded | 600 | 740 | 22 | 75 | 70 | HRc |
| Heat Treatment | R _{p0,2} (MPa) | | | | | R _m (MPa) | A ₅ (%) | | Impact Energy (J) ISO-V | | Hardness | | | | | | |
| | | -40°C | -60°C | | | | | | | | | | | | | | |
| As Welded | 600 | 740 | 22 | 75 | 70 | HRc | | | | | | | | | | | |
| REDRYING | Not required | | | | | | | | | | | | | | | | |
| GAS ACC. EN ISO 14175 | M21 | | | | | | | | | | | | | | | | |



CEWELD AA M550

AA M550 1,2MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| K-300 | 16 | 8720663405418 |