



CEWELD AA M550

TYPE Gas shielded seamless metal-cored wire for M21

APPLICATIONS Crane, steel, vessel and apparatus construction, offshore, lifting, drilling platforms etc.

PROPRIÉTÉS Seamless metal cored wire with remarkable stable arc and no spatters. Excellent for use in automated welding applications such as orbital Mag or robotic welding. This wire offers a unique welding deposit with more than 2% nickel to offer reliable impact properties down to -60°C. CEWELD AA M550 is used for welding 550 MPa yield strength steels, due to the seamless production process the hydrogen content is below 3ml/100gr weld metal even after long storage in unconditioned condition.

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

CONVIENT POUR

$R_{eh} \leq 550$ 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

AGRÉMENTS CE

POSITIONS DE SOUDAGE



ANALYSE CHIMIQUE
 TYPIQUE DU MÉTAL DE
 SOUDURE (%)

C	Si	Mn	P	S	Ni
0.05	0.7	1.3	0.015	0.015	2.2

PROPRIÉTÉS MÉCANIQUES

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

ETUVAGE Not required

GAS ACC. EN ISO 14175 M21



CEWELD AA M550

AA M550 1,2MM

Packaging	KG/unit	EanCode
K-300	16	8720663405418