



CEWELD AA R620

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|-----------------------|--|-----|-----------------------|--------|------------------------------------|------|---|----|---|
| TYPE | Seamless micro alloyed rutile cored wire with slag for M21 | | | | | | | | |
| ANWENDUNGEN | Offshore, Shipbuilding, pressure vessels, orbital pipe work, riser pipes, pipe lines, fine grain steels with yield strength up to 620 MPa (90 ksi). | | | | | | | | |
| EIGENSCHAFTEN | Excelent weld puddle manipulation and overal welding properties with extreme low hydrogen content (below 3 ml/100 gr. weld metal). Due to the addition of molybdenium suitable for post weld heat treatment respecting the impact properties. | | | | | | | | |
| KLASSIFIKATION | <table border="0"> <tr> <td>AWS</td> <td>A 5.29: E101T1-K3M H4</td> </tr> <tr> <td>EN ISO</td> <td>18276-A: T 62 4 1,5NiMo P M21 1 H5</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>2</td> </tr> </table> | AWS | A 5.29: E101T1-K3M H4 | EN ISO | 18276-A: T 62 4 1,5NiMo P M21 1 H5 | F-nr | 6 | FM | 2 |
| AWS | A 5.29: E101T1-K3M H4 | | | | | | | | |
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| F-nr | 6 | | | | | | | | |
| FM | 2 | | | | | | | | |
| GEEIGNET FÜR | <p>Reh ≤ 620 MPa ISO 15608: ~3.1, 2.2</p> <p>1.8864, 1.8873, 1.8881, 1.8928, 1.8977, 1.8924, 1.8909, 1.8984, 1.8926, 1.8904, 1.8986 S500Q-S620Q, S500QL-S620QL, L485MB-L555MB, L485QB-L555QB, 620 M, PAS 460-550 ASTM A 572 Gr. 65; A 633 Gr. E; A 738 Gr. A; A 852; API 5 L X70, X80, X70Q, X80Q alform 500 M, 550 M, 600 M, aldur 550 Q, Dillimax 550, Dillimax 500, Domex 500, Domex 550</p> | | | | | | | | |

ZULASSUNGEN CE

SCHWEISSPOSITIONEN



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

| C | Mn | Si | P | S | Ni | Mo |
|------|-----|-----|-------|-------|-----|-----|
| 0.08 | 1.4 | 0.5 | 0.015 | 0.015 | 1.7 | 0.3 |

MECHANISCHE GÜTEWERTE

| Heat Treatment | R _{P0,2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | | Hardness |
|----------------|-------------------------|----------------------|--------------------|-------------------------|-------|----------|
| | | | | -20°C | -40°C | |
| As Welded | 645 | 735 | 20 | 70 | 55 | HRc |

RÜCKTROCKNUNG Not required

GAS ACC. EN ISO 14175 M21