



# CEWELD AA M550

TYPE	Gas shielded seamless metal-cored wire for M21																
APPLICATIONS	Crane, steel, vessel and apparatus construction, offshore, lifting, drilling platforms etc.																
PROPERTIES	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	<table border="0"> <tr> <td>AWS</td> <td>A 5.36: E91T15-M21A8-K7-H4</td> </tr> <tr> <td>EN ISO</td> <td>18276-A: T 55 6 Mn2,5Ni M 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 5.36: E91T15-M21A8-K7-H4	EN ISO	18276-A: T 55 6 Mn2,5Ni M M21 1 H5	F-nr	6	FM	2								
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SUITABLE FOR	<p>Reh ≤ 550 MPa ISO 15608: 1.3, ~3.1, ~2.2, 2.1, 1.6780</p> <p>ESTE 550, S550QL</p> <p><b>HY 80</b></p> <p>15NiCrMo10-6</p> <p>API 5 L X52, X60, X65, X52Q, X60Q, X65Q, X80</p>																
APPROVALS	CE																
WELDING POSITIONS																	
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Ni</th> </tr> </thead> <tbody> <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> </tbody> </table>	C	Si	Mn	P	S	Ni	0.05	0.7	1.3	0.015	0.015	2.2				
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		-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