



CEWELD AA B550

TYPE Basic seamless micro alloyed flux cored welding wire

APPLICATIONS Vessel and apparatus construction, offshore, lifting, drilling platforms etc.

PROPERTIES AA B550 is a seamless high basic flux cored wire for extreme requirements at sub zero temperatures down to -60 °C. Excellent welding properties. Yield strength > 550 MPa. Low hydrogen content HD< 3 ml/100g even after long storage.

CLASSIFICATION

| | |
|--------|----------------------------------|
| AWS | A 5.29: E80T5-K1M-J H4 |
| EN ISO | 18276-A: T 55 6 1NiMo B M21 1 H5 |
| F-nr | 6 |
| FM | 2 |

SUITABLE FOR **Typical for: Reh ≤ 550 MPa ISO 15608: 1.2, 1.3, 2.1, 2.2, 3.1**
 1.8905 , 1.8907, 1.8937 , 1.8915, 1.8917, 1.8944 , 1.8954, 1.6780, 1.8817, 1.6368, 1.8807
 15NiCuMoNb5, 17MnMoV53, WB36, 20MnMoNi4-5, WB35, BHW 35 , BHW 38, X42, X60, X80
 StE 460, StE 500, WStE 500 , TStE 460, TStE 500, NAXTRA 56 , NAXTRA 63

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

| C | Si | Mn | P | S | Ni | Mo |
|------|-----|-----|-------|-------|----|-----|
| 0.05 | 0.4 | 1.2 | 0.015 | 0.015 | 1 | 0.3 |

MECHANICAL PROPERTIES

| Heat Treatment | R _{P0,2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | | Hardness |
|-----------------|-------------------------|----------------------|--------------------|-------------------------|-------|----------|
| | | | | -60°C | -40°C | |
| As Welded | 580 | 720 | 20 | 80 | 100 | HRc |
| 570°C- 620°C 1h | 680 | 550 | 25 | 65 | 50 | HRc |

REDRYING Not required

GAS ACC. EN ISO 14175 M21