



CEWELD AA R500 PIPE

| TYPE | Seamless fluxcored rutile FCAW welding wire for X65 X70 orbital pipeline welding | | | | | | | | | | | | | |
|---|--|----------------|----------------------------|----------------------|----------------------------------|-------------------------|----------|--------------------|-------------------------|----------|-------|-------|-----|-----|
| APPLICATIONS | For welding with high heat input in pipeline and general steel construction. For example X70 or L480MB when overmatching properties are required. | | | | | | | | | | | | | |
| PROPRIÉTÉS | CEWELD® AA R500 PIPE is a seamless rutile cored wire with very good modelling ability, therefore excellent all-position welding with higher currents. For use down to -60°C. Particularly suitable for MAG-orbital welding and for welding on ceramics in all positions, made for welding with high heat input. Low spatter loss, and remarkable easy slag removal. Due to the seamless manufacturing process, there is an extremely low diffusible hydrogen content (on average less than 3 ml/100 g) in the weld metal. For the entire storage and processing time < 4ml/100g is guaranteed according to AWS. | | | | | | | | | | | | | |
| CLASSIFICATION | <table border="0"> <tr> <td>AWS</td> <td>A 5.36: E81T1-M21A8-Ni1-H4</td> </tr> <tr> <td>EN ISO</td> <td>17632-A: T 50 4 Mn1Ni P M21 1 H5</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>1</td> </tr> </table> | AWS | A 5.36: E81T1-M21A8-Ni1-H4 | EN ISO | 17632-A: T 50 4 Mn1Ni P M21 1 H5 | F-nr | 6 | FM | 1 | | | | | |
| AWS | A 5.36: E81T1-M21A8-Ni1-H4 | | | | | | | | | | | | | |
| EN ISO | 17632-A: T 50 4 Mn1Ni P M21 1 H5 | | | | | | | | | | | | | |
| F-nr | 6 | | | | | | | | | | | | | |
| FM | 1 | | | | | | | | | | | | | |
| CONVIENT POUR | <p>ReH ≤ 500 MPa ISO 15608: 1.1, 1.3, 2.1, 2.2 (ReH max. 500 MPa), 3.1 (ReH max. 500 MPa) 1.0580 to 1.0070, 1.8900 to 1.8905, 1.8930 to 1.8935, 1.8910 to 1.8915, 1.6217, 1.6210, 1.0481, 1.0482, 1.0551, 1.0553.</p> <p>S275N-S460N, S275NL-S460NL, S275M-S460M, S275ML-S460ML, P355N, P355NH, P460N, P460NH, P275NL1-P460NL1, P275NL2- P460NL2, L360NB, L415NB, L360MB-L450MB, L360QB-L450QB</p> <p>ASTM A 203 Gr. D, E; A 350 Gr. LF1, LF2, LF3; A 420 Gr. WPL3, WPL6; A 516 Gr. 60, 65, 70; A 572 Gr. 42, 50, 55, 60, 65; A 633 Gr. A, D, E; A 662 Gr. A, B, C; A 707 Gr. L1, L2, L3; A 738 Gr. A; A 841 A, B, C; API 5 L X52, X60, X65, X52Q, X60Q, X65Q, X70Q</p> <p>Oceanfit 52, Oceanfit 60, Oceanfit 65, Oceanfit 355, Oceanfit 420, Oceanfit 460, alform plate 460M; durostat 400, 450, 500, durostat B2, aldur 500Q, aldur 500QL, aldur 500QL1, N-A-XTRA 56</p> | | | | | | | | | | | | | |
| AGRÉMENTS | CE | | | | | | | | | | | | | |
| POSITIONS DE SOUDAGE | | | | | | | | | | | | | | |
| 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>0.08</td> <td>0.5</td> <td>1.5</td> <td>0.015</td> <td>0.015</td> <td>0.9</td> </tr> </tbody> </table> | C | Si | Mn | P | S | Ni | 0.08 | 0.5 | 1.5 | 0.015 | 0.015 | 0.9 | |
| C | Si | Mn | P | S | Ni | | | | | | | | | |
| 0.08 | 0.5 | 1.5 | 0.015 | 0.015 | 0.9 | | | | | | | | | |
| PROPRIÉTÉS MÉCANIQUES | <table border="1"> <thead> <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>Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th>-40°C</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>575</td> <td>644</td> <td>26</td> <td>90</td> <td>HRc</td> </tr> </tbody> </table> | Heat Treatment | R _{P0.2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | Hardness | -40°C | As Welded | 575 | 644 | 26 | 90 | HRc |
| Heat Treatment | R _{P0.2} (MPa) | | | | | R _m (MPa) | | A ₅ (%) | Impact Energy (J) ISO-V | Hardness | | | | |
| | | -40°C | | | | | | | | | | | | |
| As Welded | 575 | 644 | 26 | 90 | HRc | | | | | | | | | |
| ETUVAGE | Not required | | | | | | | | | | | | | |
| HEAT INPUT | HI>1,5kJ/mm: T 50 4 Mn1Ni P M21 1 H5 HI<1,5kJ/mm: T 55 4 Mn1Ni P M21 1 H5 | | | | | | | | | | | | | |
| GAS ACC. EN ISO 14175 | M21 | | | | | | | | | | | | | |



CEWELD AA R500 PIPE

AA R500 PIPE 1,2MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| BS-300 | 15 | 8720663423689 |
| D-200 | 5 | 8720663400055 |