CEWELD AA M610

certilas® THE FILLER METAL SPECIALIST

TYPE	Seamless metal-powder cored wire without slag for M21
APPLICATIONS	Steel construction, shipbuilding, pressure vessels, mechanical engineering, pipe work, offshore, crane building, heavy transport, lifting equipment respecting the NACE requirements.
PROPRIÉTÉS	Seamless metal cored wire with remarkable stable arc and no spatters. Excelent for use in automated welding applications such as orbital Mag or robotic welding.This wire offers a unique covering range that anables you to use only one wire to cover more procedures upto 620N/mm2 yield strenght steels. AA M610 can also be used for constructions that needs post weld heat treatment after welding and still offers excellent impact properties. Due to the seamless production process the hydrogen content is below 3ml/100gr weld metal even after long storage.

CLASSIFICATION

AWS	A 5.28: E100C-K3 H4
EN ISO	18276-A: T 62 6 Mn1NiMo M M21 1 H5
F-nr	6
FM	2

CONVIENT POUR

Reh < 6200 MPa Iso 15608: ~3.2 (460 < Reh ≤ 690 MPa)
S620Q, S620QL, S620QL1-S620QL1, 20MnCr65, 28CrMn43
L480 - L550, X65, X80, X90
ASTM A 514 Gr. F, H, Q; A 709 Gr. 100 Type B, E, F, H, Q; A 709 Gr. HPS 100W
Weldox 600, Dillimax, S690QL1, Hardox, Naxtra 63, Naxtra 70, Optim 600 mc plus, Weldox 500, Hardox, Domex 460 MC, Domex 500 MC, Domex 550 MC, Domex 600 MC, Domex 650 MC, Domex 600 MC, Hardox 400, XAR 400, Dillidur 400, Oceanfit 100, Oceanfit 600, alform plate 620 M, aldur 620 Q, 620 QL, 620 QL1,

AGRÉMENTS

POSITIONS DE SOUDAGE

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Cr	Ni	Mo	V	Cu
0.06	0.6	1.7	0.007	0.014	0.03	0.93	0.46	0.001	0.07

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness
As Welded	634	711	25	HRc

ETUVAGE: Not required

GAS ACC. EN ISO 14175: M21

CEWELD AA M610

AA M610 1,2MM

Packaging	KG/unit	EanCode
K-300	16	8720663423443