



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								
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																
SUITABLE FOR	Reh ≤ 550 MPa ISO 15608: 1.3, ~3.1, ~2.2, 2.1, 1.6780 ESTe 550, S550QL HY 80 15NiCrMo10-6 API 5 L X52, X60, X65, X52Q, X60Q, X65Q, X80																
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				
C	Si	Mn	P	S	Ni												
0.05	0.7	1.3	0.015	0.015	2.2												
MECHANICAL PROPERTIES	<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 colspan="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th>-40°C</th> <th>-60°C</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>600</td> <td>740</td> <td>22</td> <td>75</td> <td>70</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	-60°C	As Welded	600	740	22	75	70	HRc
Heat Treatment	R _{P0,2} (MPa)					R _m (MPa)	A ₅ (%)		Impact Energy (J) ISO-V		Hardness						
		-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