




# CEWELD AA B500

| TYPE  | Fil fourré basique cuivré micro-allié   |                |                  |          |                                 |                         |        |                         |          |       |          |       |           |     |     |    |    |     |  |  |                 |     |     |    |     |    |    |     |
|---|---|----------------|------------------|----------|---------------------------------|-------------------------|--------|-------------------------|----------|-------|----------|-------|-----------|-----|-----|----|----|-----|--|--|-----------------|-----|-----|----|-----|----|----|-----|
| APPLICATIONS                                | Récipients sous pression, chaudières à vapeur, colonnes montantes, exigences de basse température, constructions très exigeantes et sollicitées nécessitant un traitement thermique après soudage.  |                |                  |          |                                 |                         |        |                         |          |       |          |       |           |     |     |    |    |     |  |  |                 |     |     |    |     |    |    |     |
| PROPRIÉTÉS                                  | AA B500 est un fil fourré tubulaire cuivré hautement basique pour les exigences offshore extrêmes à des températures inférieures à zéro jusqu'à - 60 °C (-80 °C). Excellentes propriétés de soudage. Convient donc au construction économique des aciers de construction à grains fins, à haute résistance et basse température, avec Rp0,2 > 500 MPa. Faible teneur en hydrogène HD< 3 ml/100 g même après un stockage prolongé.   |                |                  |          |                                 |                         |        |                         |          |       |          |       |           |     |     |    |    |     |  |  |                 |     |     |    |     |    |    |     |
| CLASSIFICATION                              | <table border="0"> <tr> <td>AWS</td> <td>A 5.29: E80T5-Ni</td> </tr> <tr> <td>EN ISO</td> <td>17632-A: T 50 6 1 Ni B M21 3 H5</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>1</td> </tr> </table>   | AWS            | A 5.29: E80T5-Ni | EN ISO   | 17632-A: T 50 6 1 Ni B M21 3 H5 | F-nr                    | 6      | FM                      | 1        |       |          |       |           |     |     |    |    |     |  |  |                 |     |     |    |     |    |    |     |
| AWS   | A 5.29: E80T5-Ni  |                |                  |          |                                 |                         |        |                         |          |       |          |       |           |     |     |    |    |     |  |  |                 |     |     |    |     |    |    |     |
| EN ISO                                      | 17632-A: T 50 6 1 Ni B M21 3 H5   |                |                  |          |                                 |                         |        |                         |          |       |          |       |           |     |     |    |    |     |  |  |                 |     |     |    |     |    |    |     |
| F-nr  | 6   |                |                  |          |                                 |                         |        |                         |          |       |          |       |           |     |     |    |    |     |  |  |                 |     |     |    |     |    |    |     |
| FM  | 1   |                |                  |          |                                 |                         |        |                         |          |       |          |       |           |     |     |    |    |     |  |  |                 |     |     |    |     |    |    |     |
| CONVIENT POUR                               | <p><b>Reh ≤ 500 MPa, ISO 15608: 1.3, 2.1, 2.3</b></p> <p>S355JR, S355J0, S355J2, S450J0, S355N-S460N, S355NL-S460NL, S355M-S460M, S355ML-S460ML, S460Q, S500Q, S460QL, S500QL, S460QL1, S500QL1, P355GH, P355NH, P420NH, P460NH, P355N-P460N, P355NH-P460NH, P355NL1-P460NL1, P355NL2- P460NL2, L245NB- L415NB, L245MB-L485MB, L360QB-L485QB</p> <p>ASTM A 350 Gr. LF2; A 516 Gr. 65, 70; A 572 Gr. 42, 50, 60, 65; A 573 Gr. 70; A 588 Gr. B, C, K; A 633 Gr. A, C, D, E; A 662 Gr. B, C; A 678 Gr. B; A 707 Gr. L2, L3; A 841 Gr. A, B, C;</p> <p>API 5 L X42, X52, X60, X65, X70, X52Q, X60Q, X65Q, X70Q,</p> <p>aldur 500Q, aldur 500QL, aldur 500QL1, Domex 420 -500 MC,MC Plus, ML, Dilimax 460 -500,</p> |                |                  |          |                                 |                         |        |                         |          |       |          |       |           |     |     |    |    |     |  |  |                 |     |     |    |     |    |    |     |
| AGRÉMENTS                                   | CE  |                |                  |          |                                 |                         |        |                         |          |       |          |       |           |     |     |    |    |     |  |  |                 |     |     |    |     |    |    |     |
| POSITIONS DE SOUDAGE                        |    |                |                  |          |                                 |                         |        |                         |          |       |          |       |           |     |     |    |    |     |  |  |                 |     |     |    |     |    |    |     |
| TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%) | <table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <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>0.7</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                    | 0.7      | 1.5   | 0.015    | 0.015 | 0.9       |     |     |    |    |     |  |  |                 |     |     |    |     |    |    |     |
| C   | Si  | Mn             | P                | S        | Ni                              |                         |        |                         |          |       |          |       |           |     |     |    |    |     |  |  |                 |     |     |    |     |    |    |     |
| 0.08  | 0.7   | 1.5            | 0.015            | 0.015    | 0.9                             |                         |        |                         |          |       |          |       |           |     |     |    |    |     |  |  |                 |     |     |    |     |    |    |     |
| PROPRIÉTÉS MÉCANIQUES                       | <table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">Rp0,2 (MPa)</th> <th rowspan="2">Rm (MPa)</th> <th rowspan="2">A5 (%)</th> <th colspan="3">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th>-80°C</th> <th>-40°C</th> <th>-60°C</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>540</td> <td>620</td> <td>23</td> <td>50</td> <td colspan="2">HRc</td> <td></td> </tr> <tr> <td>570°C- 620°C 1h</td> <td>560</td> <td>645</td> <td>26</td> <td>120</td> <td>95</td> <td>70</td> <td>HRc</td> </tr> </tbody> </table>   | Heat Treatment | Rp0,2 (MPa)      | Rm (MPa) | A5 (%)                          | Impact Energy (J) ISO-V |        |                         | Hardness | -80°C | -40°C    | -60°C | As Welded | 540 | 620 | 23 | 50 | HRc |  |  | 570°C- 620°C 1h | 560 | 645 | 26 | 120 | 95 | 70 | HRc |
| Heat Treatment                              | Rp0,2 (MPa)   |                |                  |          |                                 | Rm (MPa)                | A5 (%) | Impact Energy (J) ISO-V |          |       | Hardness |       |           |     |     |    |    |     |  |  |                 |     |     |    |     |    |    |     |
|   |   | -80°C          | -40°C            | -60°C    |                                 |                         |        |                         |          |       |          |       |           |     |     |    |    |     |  |  |                 |     |     |    |     |    |    |     |
| As Welded                                   | 540   | 620            | 23               | 50       | HRc                             |                         |        |                         |          |       |          |       |           |     |     |    |    |     |  |  |                 |     |     |    |     |    |    |     |
| 570°C- 620°C 1h                             | 560   | 645            | 26               | 120      | 95                              | 70                      | HRc    |                         |          |       |          |       |           |     |     |    |    |     |  |  |                 |     |     |    |     |    |    |     |
| ETUVAGE                                     | Non requis  |                |                  |          |                                 |                         |        |                         |          |       |          |       |           |     |     |    |    |     |  |  |                 |     |     |    |     |    |    |     |
| GAS ACC. EN ISO 14175                       | M21   |                |                  |          |                                 |                         |        |                         |          |       |          |       |           |     |     |    |    |     |  |  |                 |     |     |    |     |    |    |     |



# CEWELD AA B500

AA B500 1,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| K-300     | 16      | 8720663405371 |