



CEWELD AA R620

TYPE	Seamless micro alloyed rutile cored wire with slag for M21																	
TOEPASSINGEN	Offshore, Shipbuilding, pressure vessels, orbital pipe work, riser pipes, pipe lines, fine grain steels with yield strength up to 620 MPa (90 ksi).																	
EIGENSCHAPPEN	Excelent weld puddle manipulation and overal welding properties with extreme low hydrogen content (below 3 ml/100 gr. weld metal). Due to the addition of molybdenium suitable for post weld heat treatment respecting the impact properties.																	
CLASSIFICATIE	AWS	A 5.29: E101T1-K3M H4																
	EN ISO	18276-A: T 62 4 1,5NiMo P M21 1 H5																
	F-nr	6																
	FM	2																
GESCHIKT VOOR	Reh ≤ 620 MPa ISO 15608: ~3.1, 2.2 1.8864, 1.8873, 1.8881, 1.8928, 1.8977, 1.8924, 1.8909, 1.8984, 1.8926, 1.8904, 1.8986 S500Q-S620Q, S500QL-S620QL, L485MB-L555MB, L485QB-L555QB, 620 M, PAS 460-550 ASTM A 572 Gr. 65; A 633 Gr. E; A 738 Gr. A; A 852; API 5 L X70, X80, X70Q, X80Q alform 500 M, 550 M, 600 M, aldur 550 Q, Dillimax 550, Dillimax 500, Domex 500, Domex 550																	
GOEDKEURINGEN	CE																	
LASPOSITIES																		
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Mn</th> <th>Si</th> <th>P</th> <th>S</th> <th>Ni</th> <th>Mo</th> </tr> </thead> <tbody> <tr> <td>0.08</td> <td>1.4</td> <td>0.5</td> <td>0.015</td> <td>0.015</td> <td>1.7</td> <td>0.3</td> </tr> </tbody> </table>	C	Mn	Si	P	S	Ni	Mo	0.08	1.4	0.5	0.015	0.015	1.7	0.3			
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HERDROGEN	Not required																	
GAS ACC. EN ISO 14175	M21																	