CEWELD AA R620

certilas® THE FILLER METAL SPECIALIST

TYPE	Seamless micro alloyed rutile cored wire with slag for M21
ANWENDUNGEN	Offshore, Shipbuilding, pressure vessels, orbital pipe work, riser pipes, pipe lines, fine grain steels with yield strength up to 620 MPa (90 ksi).
EIGENSCHAFTEN	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.

KLASSIFIKATION

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

GEEIGNET FÜR

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

ZULASSUNGEN: CE

SCHWEISSPOSITIONEN

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Mn	Si	P	S	Ni	Mo
0.08	1.4	0.5	0.015	0.015	1.7	0.3

MECHANISCHE GÜTEWERTE

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				-20°C	-40°C	
As Welded	645	735	20	70	55	HRc

RÜCKTROCKNUNG: Not required

GAS ACC. EN ISO 14175: M21