CEWELD AA R690

certilas® THE FILLER METAL SPECIALIST

TYPE

Seamless micro-alloyed rutile flux-cored wire for high strength steels

ANWENDUNGEN

Shipbuilding, steel and vessel construction, mechanical engineering and pipe work, offshore, crane building, lifting, platforms. Steels with yield strength up to 690 MPa (100 ksi).

EIGENSCHAFTEN

CEWELD® AA R690 was one of "The first seamless rutile FCW with extreme low hydrogen for S690" Excellent for use in positional welding where high deposition rate is required, suitable for temperatures down to -60 °C (with offshore Approval down to -40°C). Excellent for use on ceramic backing and Mag orbital welding in all positions. Extreme low spatter properties and excellent arc stability with fast freezing slag.

KLASSIFIKATION

AWS	A 5.29: E 111T1-GM-J H4
EN ISO	18276-A: T 69 6 Z P M21 1 H5
F-nr	6
FM	2

GEEIGNET FÜR

Reh < 690 MPa Iso 15608: 2.2 u 3.2 (460 < Reh ≤ 690(700) MPa)
1.8914, 1.8927, 1.8931, 1.8928, 1.8974, 1.7147, 1.7149, 1.8734
S620Q, S620QL, S690Q, S690QL, S620QL1-S690QL1, 20MnCr65, 28CrMn4-3
L480 - L550, X65, X80, X90, X100
ASTM A 514 Gr. F, H, Q; A 709 Gr. 100 Type B, E, F, H, Q; A 709 Gr. HPS 100W
Weldox 700, Dillimax 690, Hardox, Naxtra 63, Naxtra 70, Optim 700 mc plus, Weldox 500, Hardox, Domex 460 MC, Domex 500 MC, Domex 550 MC, Domex 600 MC, Domex 650 MC, Domex 700 MC, Hardox 400,Strenx 700; XAR 400, Dillidur 400, Oceanfit 100, Oceanfit 690, alform plate 620 M, 700 M, aldur 620 Q, 620 QL, 620 QL1, aldur 700 Q, 700 QL, 700 QL1, Salzgitter S700MC, Ympress Steel E690 TM, S700MC, Amstrong Ultra 650MC, 650 MCt, 700 MC.....

ZULASSUNGEN

CE, Lloyds, DNV

SCHWEISSPOSITIONEN

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Cr	Ni	Mo
0.06	0.4	1.6	0.015	0.015	0.3	2.2	0.3

MECHANISCHE GÜTEWERTE

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				-40°C	-60°C	
As Welded	705	850	20	75	50	HRc

RÜCKTROCKNUNG

Not required

GAS ACC. EN ISO 14175

M21

CEWELD AA R690

AA R690 1,2MM

Packaging	KG/unit	EanCode
BS-300	16	8720663423733
D-200	20 (4x5)	8720663423726