CEWELD AA R610

certilas® THE FILLER METAL SPECIALIST

TYPE	Seamless micro alloyed rutile cored wire with slag for M21
APPLICATIONS	Offshore, Shipbuilding, pressure vessels, orbital pipe work respecting the NACE requirements. Steels with yield strength up to 620 MPa (90 ksi).
PROPERTIES	Very good modeling ability, therefore excellent all-position welding with higher currents. For use down to -40 °C (- 40 °F) .. Particularly suitable for MAG-orbital welding and for weldings on ceramics in all positions. Low spatter loss, and remarkable easy slag removal.

CLASSIFICATION

AWS	A 5.29: E101T1-K2M H4
EN ISO	18276-A: T 62 4 Mn1Ni P M21 1 H5
F-nr	6
FM	2

SUITABLE FOR

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

APPROVALS: CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Cr	Ni	Mo	Cu
0.062	0.55	1.6	0.006	0.014	0.02	0.98	0.012	0.07

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V	Hardness
				-40°C	
As Welded	635	715	28	105	HRc

REDRYING: Not required

GAS ACC. EN ISO 14175: M21

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AA R610 1,2MM

Packaging	KG/unit	EanCode
D-200	20 (4x5)	8720663423702
K-300	16	8720663423719