


CEWELD AA B500

| TYPE | Basisch gevulde naadloze lasdraad | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|--|----------------|------------------|----------|---------------------------------|-------------------------|--------|-------------------------|----------|-------|----------|-------|-----------|-----|-----|----|----|-----|--|--|-----------------|-----|-----|----|-----|----|----|-----|
| TOEPASSINGEN | Drukvaten, stoomketels, stijgbuizen, lage temperatuurvereisten. Geschikt voor veeleisende en belaste constructies die een warmtebehandeling na het lassen nodig hebben. | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| EIGENSCHAPPEN | AA B500 is een naadloze hoge basis gevulde draad voor extreme offshore toepassingen bij temperaturen tot - 60°C. Uitstekende laseigenschappen. Daarom geschikt voor het economisch verwerken van fijnkorrelig constructiestaal met hoge sterkte en lage gebruikstemperatuur met Rp0,2 > 500 MPa. Constructiestalen met Rp0,2 > 500 MPa. Laag waterstofgehalte HD< 3 ml/100g, zelfs na langdurige opslag. | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| CLASSIFICATIE | <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 | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| GESCHIKT VOOR | <p>Reh ≤ 500 MPa, ISO 15608: 1.3, 2.1, 2.3</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, aldur 500Q, aldur 500QL, aldur 500QL1, Domex 420 -500 MC,MC Plus, ML, Dilimax 460 -500,</p> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| GOEDKEURINGEN | CE | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| LASPOSITIES |  | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%) | <table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td style="width: 16.6%;">C</td> <td style="width: 16.6%;">Si</td> <td style="width: 16.6%;">Mn</td> <td style="width: 16.6%;">P</td> <td style="width: 16.6%;">S</td> <td style="width: 16.6%;">Ni</td> </tr> <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> </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 | | | | | | | | | | | | | | | | | | | | | | | |
| MECHANISCHE WAARDEN | <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 | | | | | | | | | | | | | | | | | | | | | |
| HERDROGEN | Not required | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| GAS ACC. EN ISO 14175 | M21 | | | | | | | | | | | | | | | | | | | | | | | | | | | |



CEWELD AA B500

AA B500 1,2MM

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