



# CEWELD AA M550

TYPE	Gas shielded seamless metal-cored wire for M21																
APPLICATIONS	Crane, steel, vessel and apparatus construction, offshore, lifting, drilling platforms etc.																
PROPRIÉTÉS	Seamless metal cored wire with remarkable stable arc and no spatters. Excellent for use in automated welding applications such as orbital Mag or robotic welding. This wire offers a unique welding deposit with more than 2% nickel to offer reliable impact properties down to -60°C. CEWELD AA M550 is used for welding 550 MPa yield strength steels, due to the seamless production process the hydrogen content is below 3ml/100gr weld metal even after long storage in unconditioned condition.																
CLASSIFICATION	AWS A 5.36: E91T15-M21A8-K7-H4 EN ISO 18276-A: T 55 6 Mn2,5Ni M M21 1 H5, 18276-A: T 55 6 1NiMo M M21 1 H5 F-nr 6 FM 2																
CONVIENT POUR	Reh ≤ 550 MPa ISO 15608: 1.3, ~3.1, ~2.2, 2.1, 1.6780 ESTe 550, S550QL HY 80 15NiCrMo10-6, G19NiCrMo 12-6 A 543M, A 537M API 5 L X52, X60, X65, X52Q, X60Q, X65Q, X80																
AGRÉMENTS	CE																
POSITIONS DE SOUDAGE																	
ANALYSE CHIMIQUE TYPIQUE DU MÉTAL DE SOUDURE (%)	<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>0.05</td> <td>0.7</td> <td>1.3</td> <td>0.015</td> <td>0.015</td> <td>2.2</td> </tr> </table>	C	Si	Mn	P	S	Ni	0.05	0.7	1.3	0.015	0.015	2.2				
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PROPRIÉTÉS MÉCANIQUES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R<sub>P0,2</sub> (MPa)</th> <th rowspan="2">R<sub>m</sub> (MPa)</th> <th rowspan="2">A<sub>5</sub> (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th>-40°C</th> <th>-60°C</th> </tr> <tr> <td>As Welded</td> <td>600</td> <td>740</td> <td>22</td> <td>75</td> <td>70</td> <td>HRC</td> </tr> </table>	Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness	-40°C	-60°C	As Welded	600	740	22	75	70	HRC
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		-40°C	-60°C														
As Welded	600	740	22	75	70	HRC											
ETUVAGE	Not required																
GAS ACC. EN ISO 14175	M21																



# CEWELD AA M550

AA M550 1,2MM

Packaging	KG/unit	EanCode
K-300	16	8720663405418