



# CEWELD AA B500

|                                                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                              |                      |                    |                         |       |       |          |
|----------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------|----------------------|--------------------|-------------------------|-------|-------|----------|
| TYPE                                               | Basic seamless micro alloyed flux cored welding wire                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                              |                      |                    |                         |       |       |          |
| ANWENDUNGEN                                        | Pressure vessels, steam boilers, riser pipes, low temperature requirements, high demanding and stressed constructions that needs post weld heat treatment.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                                              |                      |                    |                         |       |       |          |
| EIGENSCHAFTEN                                      | AA B500 is a seamless high basic flux cored wire for extreme offshore requirements at sub zero temperatures down to - 60 °C (-80°C). Excellent welding properties. Therefore, suitable for the economic processing of high-strength, low temperature fine-grained structural steels with Rp0,2 > 500 MPa. Low hydrogen content HD< 3 ml/100g even after long storage.                                                                                                                                                                                                                                                                                                                    |                                              |                      |                    |                         |       |       |          |
| KLASSIFIKATION                                     | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | A 5.29: E80T5-Ni, A 5.36: E80T5-M21A8-Ni1-H4 |                      |                    |                         |       |       |          |
|                                                    | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | 17632-A: T 50 6 1 Ni B M21 3 H5              |                      |                    |                         |       |       |          |
|                                                    | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | 6                                            |                      |                    |                         |       |       |          |
|                                                    | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | 1                                            |                      |                    |                         |       |       |          |
| GEEIGNET FÜR                                       | <b>Reh ≤ 500 MPa, ISO 15608: 1.3, 2.1, 2.3</b><br>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<br>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;<br>API 5 L X42, X52, X60, X65, X70, X52Q, X60Q, X65Q, X70Q,<br>aldur 500Q, aldur 500QL, aldur 500QL1, Domex 420 -500 MC,MC Plus, ML, Dilimax 460 -500, |                                              |                      |                    |                         |       |       |          |
| ZULASSUNGEN                                        | CE                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                                              |                      |                    |                         |       |       |          |
| SCHWEISSPOSITIONEN                                 | <div>   </div>                                                                                                                                                                                                                                                                                                                               |                                              |                      |                    |                         |       |       |          |
| TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | Si                                           | Mn                   | P                  | S                       | Ni    |       |          |
|                                                    | 0.08                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | 0.7                                          | 1.5                  | 0.015              | 0.015                   | 0.9   |       |          |
| MECHANISCHE GÜTEWERTE                              | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | R <sub>P0,2</sub> (MPa)                      | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |       |       | Hardness |
|                                                    | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | 540                                          | 620                  | 23                 | -80°C                   | -40°C | -60°C |          |
|                                                    | 570°C- 620°C 1h                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | 560                                          | 645                  | 26                 | 50                      | HRc   | 70    | HRc      |
| RÜCKTROCKNUNG                                      | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                                              |                      |                    |                         |       |       |          |
| GAS ACC. EN ISO 14175                              | M21                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                                              |                      |                    |                         |       |       |          |



# CEWELD AA B500

AA B500 1,2MM

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