



CEWELD AA R500 PIPE

TYPE	Seamless rutile flux cored wire with < 1% Ni, for FCAW orbital welding (H2-Ready) S480 and X80 steel grades. (Type E 81-T1, T 50 4)													
APPLICATIONS	CEWELD® AA R500 PIPE is a seamless rutile cored wire with very good modelling properties that is ideal for constrained position welding with higher amperages. Particularly suitable for orbital welding and generally for welding on weld pool protection in all positions, even with high heat input. CEWELD® AA R500 PIPE is suitable for the following applications: Pipeline and tank construction (H2-Ready), steel and shipbuilding as well as offshore and onshore applications.													
PROPERTIES	CEWELD® AA R500 PIPE is ideal for welding in all positions with higher currents. Can be used down to -40°C (-60°C). It has low spatter losses and remarkably easy slag removal. Due to the seamless manufacturing process, the content of diffusible hydrogen in the weld metal is extremely low (on average less than 3 ml/100 g). For the entire storage and processing time, < 4 ml/100 g is guaranteed according to AWS. EN -ISO 17632-A: T 50 4 Mn1Ni P M21 1 H5 (for > 1.5 kJ/mm) EN -ISO 18276-A: T 55 4 Mn1Ni P M21 1 H5 (for < 1.5 kJ/mm) ASME -AWS A 5. 36: E81T1-M21A4-Ni1-H4 (for > 1.5 kJ/mm) ASME - AWS A 5.36: E91T1-M21A4-Ni1-H4 (for < 1.5 kJ/mm)													
CLASSIFICATION	AWS A 5.36: E81T1-M21A8-Ni1-H4, A 5.36: E91T1-M21A8-Ni1-H4 EN ISO 17632-A: T 50 4 Mn1Ni P M21 1 H5, 18276-A: T 55 4 Mn1Ni P M21 1 H5 F-nr 6 FM 1													
SUITABLE FOR	ReH ≤ 500 MPa ISO 15608: 1.1, 1.3, 2.1, 2.2 (ReH max. 500 MPa), 3.1 (ReH max. 500 MPa) 1.0580 to 1.0070, 1.8900 to 1.8905, 1.8930 to 1.8935, 1.8910 to 1.8915, 1.6217, 1.6210, 1.0481, 1.0482, 1.0551, 1.0553. S275N-S460N, S275NL-S460NL, S275M-S460M, S275ML-S460ML, P355N, P355NH, P460N, P460NH, P275NL1-P460NL1, P275NL2- P460NL2, L360NB, L415NB, L360MB-L450MB, L360QB-L450QB ASTM A 203 Gr. D, E; A 350 Gr. LF1, LF2, LF3; A 420 Gr. WPL3, WPL6; A 516 Gr. 60, 65, 70; A 572 Gr. 42, 50, 55, 60, 65; A 633 Gr. A, D, E; A 662 Gr. A, B, C; A 707 Gr. L1, L2, L3; A 738 Gr. A; A 841 A, B, C; API 5 L X52, X60, X65, X52Q, X60Q, X65Q, X70Q Oceanfit 52, Oceanfit 60, Oceanfit 65, Oceanfit 355, Oceanfit 420, Oceanfit 460, alform plate 460M; durostat 400, 450, 500, durostat B2, aldur 500Q, aldur 500QL, aldur 500QL1, N-A-XTRA 56													
APPROVALS	CE, TÜV: (19713)													
WELDING POSITIONS														
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table><tr><td>C</td><td>Si</td><td>Mn</td><td>P</td><td>S</td><td>Ni</td></tr><tr><td>0.08</td><td>0.5</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	0.5	1.5	0.015	0.015	0.9	
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MECHANICAL PROPERTIES	<table><tr><th rowspan="2">Heat Treatment</th><th rowspan="2">R_{p0.2} (MPa)</th><th rowspan="2">R_m (MPa)</th><th rowspan="2">A₅ (%)</th><th>Impact Energy (J) ISO-V</th><th rowspan="2">Hardness</th></tr><tr><th>-40°C</th></tr><tr><td>As Welded</td><td>575</td><td>644</td><td>26</td><td>90</td><td>HRc</td></tr></table>	Heat Treatment	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V	Hardness	-40°C	As Welded	575	644	26	90	HRc
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		-40°C												
As Welded	575	644	26	90	HRc									
REDRYING	Not required													
HEAT INPUT	HI>1,5kJ/mm: T 50 4 Mn1Ni P M21 1 H5 HI<1,5kJ/mm: T 55 4 Mn1Ni P M21 1 H5													
GAS ACC. EN ISO 14175	M21													



CEWELD AA R500 PIPE

AA R500 PIPE 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663423689
D-200	5	8720663400055