

AA M500

CATEGORY	FCAW Flux-Cored																																		
TYPE	Seamless metal cored wire without slag for Ar-CO2 mix																																		
APPLICATIONS	Crane, steel, vessel and apparatus construction, offshore, lifting, drilling platforms etc.																																		
PROPERTIES	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 less than 1% nickel to full fill NACE requirements and cover more procedures upto 500N/mm2 yield strength steels. AA M500 can also be used for constructions that needs post weld heat treatment after welding and still offers mechanical properties confirming 5Y46 class. Due to the seamless production process the hydrogen content is below 3ml/100gr weld metal even after long storage in unconditioned condition.																																		
CLASSIFICATION	AWS	5.28: E 80C-Ni1H4 5.28M: E55C-Ni1 H4																																	
	EN ISO	17632-A: T 50 6 1Ni M M 1 H5																																	
SUITABLE FOR	Materials shipbuilding Unalloyed steels boiler steels pipe steels - Fine grain steels API-standard	DIN A, B, D, E, AH 32 - EH 36 St 33, St 37-2 - St 52-3 H I, H III, 17Mn4, 19Mn5 St 35.8, St 45.8 StE 210.7 TM, StE 480.7 TM StE 255 to StE 500 X 42, X65, X 70	EN same S185 - S355-S460-S485 P235GH, P355GH P235T1/T2, P460NL2 L210 - L480MB S255 - S500 (NL1,2) X 42, X65, X 70	ASTM Typical A 258 / A 516 A 662 / A 387 A 738 / A 612 A 299 - -																															
APPROVALS	CE approved																																		
WELDING POSITIONS:																																			
WELD METAL ANALYSIS % (TYPICAL M21)	<table><tr><td>C</td><td>Mn</td><td>Si</td><td>Cr</td><td>Ni</td><td>Mo</td><td>P</td><td>S</td></tr><tr><td>0.05</td><td>1.3</td><td>0.7</td><td>-</td><td>0,9</td><td>-</td><td><0.015</td><td><0.015</td></tr></table>					C	Mn	Si	Cr	Ni	Mo	P	S	0.05	1.3	0.7	-	0,9	-	<0.015	<0.015														
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REDRYING TEMPERATURE	Not required																																		
GAS ACC. EN ISO 14175:	M21, Co2																																		