

## AA B500

**CATEGORY** FCAW Flux-Cored

**TYPE** Basic seamless micro alloyed flux cored welding wire

**APPLICATIONS** Pressure vessels, steam boilers, riser pipes, low temperature requirements, high demanding and stressed constructions that needs post weld heat treatment.

**PROPERTIES** High basic seamless fluxcored welding wire for extreme offshore requirements at sub zero temperatures down to -80 degrees Celsius. Excelent welding properties and very low hydrogen content due to the seamless production proces.

**CLASSIFICATION** AWS 5.29: E 90T5-K2M-J H4

**SUITABLE FOR** X80, P500QL2, P420, S460, AISI 4130, 8630 and similar grades that require yield strength above 500 N/mm2 fulfilling NACE requirements in combination with high impact properties at extreme sub zero temperatures.

**APPROVALS** In progress, CE approved

**WELDING POSITIONS:**



**TYPICAL WELD METAL WEIGHT %**

C	Mn	Si	Cr	Ni	Cu	P	S
0,085	1.55	0,5	0,02	0,97	0,12	0,011	0,007

**MECHANICAL PROPERTIES (TYPICAL)**

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				-40°C	-60°C	-80°C	
AW	>500	>600	>23			>50	
PWHT 585°C / 2hr.	558	645	26	117	98	70	

AW: as welded / PWHT: post weld heat treatment

**WELDING PARAMETERS / PACKING**

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A) (DC+)	spool type	kg / spool / drum	kg / pallet
1,2	23-32	230-290	D-200 / K-300 / drum	5 / 16 / 300	1000 / 1024 / 600

**REDRYING TEMPERATURE** not required

**GAS ACC. EN ISO 14175:** M21