

AA M550

CATEGORY FCAW Flux-Cored

TYPE Gas shielded seamless metal-cored wire for M21

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 more than 2% nickel to offer reliable impact properties down to -60°C. Ceweld AA M550 is used for welding 550N/mm² 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 A5.36: E91T15-M21A8-K7-H4
EN ISO 18276-A: T55 6 Mn2,5Ni M M21 1 H5

SUITABLE FOR X42, X65, X70, X80, EStE 550, HY 80

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS % (TYPICAL M21)

C	Mn	Si	S	P	Ni
0.05	1.4	0.6	0.010	0.010	2.2

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
				-20°C	-40°C	-60°C	
AW	>550	640-780	18		>47	>47	

WELDING PARAMETERS / PACKING

Welding Parameters	Welding Parameters	Welding Parameters	Packing		
D (mm)	Voltage (V) (DC+)	Current (A)	spool type	kg spool	kg / pallet
1.2	15-30	90-300	K-300	16	1024

REDRYING TEMPERATURE not required

NOTE CTOD tested -40°C