

## 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/mm<sup>2</sup> 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 <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
				-20°C	-40°C	-60°C	
AW	>550	640-780	18	>47	>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