

CATEGORY	FCAW Flux-Cored
TYPE	Seamless copper coated rutile flux-cored wire for M21.
APPLICATIONS	Offshore, Shipbuilding, pressure vessels, orbital pipe work.
PROPERTIES	AA R500 SR is a seamless rutile cored wire and has excellent modelling ability, therefore excellent forced position welding in all positions at high amperage. Down to -60 °C very good impact values are achieved also with very good PWHT results. Particularly suitable for welding on ceramics in all positions. Low spatter losses, easily removable slag.

CLASSIFICATION	AWS	A 5.29: E81T1-Ni1M-J H4
	AWS	A 5.36: E81T1-M21A8-Ni1-H4
	EN ISO	17632-A: T 50 6 1Ni P M21 1 H5

SUITABLE FOR	Reh ≤ 500 MPa ISO 15608: 1.3, ~3.1, ~2.2, 2.1, 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,
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APPROVALS	CE
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TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)						
C	Si	Mn	P	S	Ni	
0.08	0.5	1.4	0.015	0.015	0.9	

ALL WELD MECHANICAL PROPERTIES				
Heat Treatment	R _{p0.2} MPa	R _m MPa	A5 (%)	Impact Energy (J) ISO-V -60°C
As Welded /	550	600	22	70
570°C- 620°C /1h	520	580	22	50

WELDING PARAMETERS / PACKING	
REDRYING TEMPERATURE	Not required
GAS ACCORDING EN 14175	M21