

CATEGORY FCAW Flux-Cored

TYPE Seamless rutile flux cored < 1% Ni wire for FCAW orbital welding S480 and X80 steel grades. (E81-T1)

APPLICATIONS CEWELD AA R500 PIPE are designed for MAG welding with high heat input in pipeline and general steel construction. Particularly suitable for MAG orbital welding and for welding on ceramics in all positions.

PROPERTIES CEWELD® AA R500 PIPE is a seamless rutile cored wire with very good modelling properties, therefore excellent all-position welding with higher currents. Applicable down to -40°C. Low spatter loss and remarkably easy slag removal. Due to the seamless manufacturing process, the content of diffusible hydrogen in the weld metal is extremely low (on average less than 3 ml/100 g). For the entire storage and processing time, < 4 ml/100 g is guaranteed according to AWS.

CLASSIFICATION	AWS	A 5.36: E81T1-M21A8-Ni1-H4
	AWS	A 5.36: E91T1-M21A8-Ni1-H4
	EN ISO	17632-A: T 50 4 Mn1Ni P M21 1 H5
	EN ISO	18276-A: T 55 4 Mn1Ni P M21 1 H5
	F-nr	6
	FM	1

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,

APPROVALS CE



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Ni
0.08	0.5	1.5	0.015	0.015	0.9

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V (-40°C)
As Welded /	575	644	26	90

WELDING PARAMETERS / PACKING

WELDING PARAMETERS	WELDING PARAMETERS	WELDING PARAMETERS	PACKING	PACKING	PACKING
D (MM)	VOLTAGE (V)	CURRENT (A) DC+	TYPE SPOOL	KG / SPOOL	KG / PALLET
1.2	22-30	160-280	D-200 / BS-300	5 / 15 / 16	1000 / 1080 / 1024

REDRYING TEMPERATURE Not required

GAS ACCORDING EN 14175 M21