


CATEGORY	FCAW Flux-Cored					
TYPE	Basic seamless micro alloyed flux cored welding wire					
APPLICATIONS	Vessel and apparatus construction, offshore, lifting, drilling platforms etc.					
PROPERTIES	AA B550 is a seamless high basic flux cored wire for extreme requirements at sub zero temperatures down to -60 °C. Excellent welding properties. Yield strength > 550 MPa. Low hydrogen content HD< 3 ml/100g even after long storage.					
CLASSIFICATION	AWS	A 5.29: E80T5-K1M-J H4				
	AWS	A 5.36: E80T5-M21A4-K1-H4				
	EN ISO	18276-A: T 55 6 1NiMo B M21 1 H5				
	F-nr	6				
	FM	2				
SUITABLE FOR	Typical for: 15NiCuMoNb5, 17MnMoV53, (WB36) 20MnMoNi4-5					
APPROVALS	No Approvals Found					
WELDING POSITIONS:						
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)						
C	Si	Mn	P	S	Ni	Mo
0.05	0.4	1.2	0.015	0.015	1.1	0.3
ALL WELD MECHANICAL PROPERTIES						
Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V -60°C		
As Welded /1h	580	720	20	80		
WELDING PARAMETERS / PACKING						
REDRYING TEMPERATURE	Not required					
GAS ACCORDING EN 14175	M21					