



# CEWELD AA B550

**TYPE** Basic seamless micro alloyed flux cored welding wire

**ANWENDUNGEN** Vessel and apparatus construction, offshore, lifting, drilling platforms etc.

**EIGENSCHAFTEN** 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.

**KLASSIFIKATION**

|        |                                                   |
|--------|---------------------------------------------------|
| AWS    | A 5.29: E80T5-K1M-J H4, A 5.36: E80T5-M21A4-K1-H4 |
| EN ISO | 18276-A: T 55 6 1NiMo B M21 1 H5                  |
| F-nr   | 6                                                 |
| FM     | 2                                                 |

**GEEIGNET FÜR** **Typical for: Reh ≤ 550 MPa ISO 15608: 1.2, 1.3, 2.1, 2.2, 3.1**  
1.8905 , 1.8907, 1.8937 , 1.8915, 1.8917, 1.8944 , 1.8954, 1.6780, 1.8817, 1.6368, 1.8807  
15NiCuMoNb5, 17MnMoV53, WB36, 20MnMoNi4-5, WB35, BHW 35 , BHW 38, X42, X60, X80  
StE 460, StE 500, WStE 500 , TStE 460, TStE 500, NAXTRA 56 , NAXTRA 63

**ZULASSUNGEN**

**SCHWEISSPOSITIONEN**



**TYPISCHE CHEMISCHE  
ANALYSE DES  
SCHWEISSMETALLS (%)**

| C    | Si  | Mn  | P     | S     | Ni | Mo  |
|------|-----|-----|-------|-------|----|-----|
| 0.05 | 0.4 | 1.2 | 0.015 | 0.015 | 1  | 0.3 |

**MECHANISCHE GÜTEWERTE**

| Heat Treatment  | R <sub>P0,2</sub><br>(MPa) | R <sub>m</sub><br>(MPa) | A <sub>5</sub><br>(%) | Impact Energy (J) ISO-V |       | Hardness |
|-----------------|----------------------------|-------------------------|-----------------------|-------------------------|-------|----------|
|                 |                            |                         |                       | -60°C                   | -40°C |          |
| As Welded       | 580                        | 720                     | 20                    | 80                      | 100   | HRc      |
| 570°C- 620°C 1h | 680                        | 550                     | 25                    | 65                      | 50    | HRc      |

**RÜCKTROCKNUNG** Not required

**GAS ACC. EN ISO 14175** M21