

# CEWELD AA R610

TYPE	Seamless micro alloyed rutile cored wire with slag for M21	
ANWENDUNGEN	Offshore, Shipbuilding, pressure vessels, orbital pipe work respecting the NACE requirements. Steels with yield strength up to 620 MPa (90 ksi).	
EIGENSCHAFTEN	Very good modeling ability, therefore excellent all-position welding with higher currents. For use down to -40 °C (- 40 °F) .. Particularly suitable for MAG-orbital welding and for weldings on ceramics in all positions. Low spatter loss, and remarkable easy slag removal.	
KLASSIFIKATION	AWS	A 5.29: E101T1-K2M H4
	EN ISO	18276-A: T 62 4 Mn1Ni P M21 1 H5
	F-nr	6
	FM	2

GEEIGNET FÜR **Reh ≤ 620 MPa ISO 15608: ~3.1, 2.2**  
 1.8864, 1.8873, 1.8881, 1.8928, 1.8977, 1.8924, 1.8909, 1.8984, 1.8926, 1.8904, 1.8986  
 S500Q-S620Q, S500QL-S620QL, L485MB-L555MB, L485QB-L555QB, 620 M, PAS 460-550  
 ASTM A 572 Gr. 65; A 633 Gr. E; A 738 Gr. A; A 852;  
 API 5 L X70, X80, X70Q, X80Q  
 alform 500 M, 550 M, 600 M, aldur 550 Q, Dillimax 550, Dillimax 500, Domex 500, Domex 550

ZULASSUNGEN CE

SCHWEISSPOSITIONEN



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

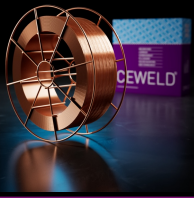
C	Si	Mn	P	S	Cr	Ni	Mo	Cu
0.062	0.55	1.6	0.006	0.014	0.02	0.98	0.012	0.07

MECHANISCHE GÜTEWERTE

Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V	Hardness
				-40°C	
As Welded	635	715	28	105	HRc

RÜCKTROCKNUNG Not required

GAS ACC. EN ISO 14175 M21



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AA R610 1,2MM

Packaging	KG/unit	EanCode
D-200	20 (4x5)	8720663423702
K-300	16	8720663423719