



# CEWELD AA R620

**TYPE** Seamless micro alloyed rutile cored wire with slag for M21

**APPLICATIONS** Offshore, Shipbuilding, pressure vessels, orbital pipe work, riser pipes, pipe lines, fine grain steels with yield strength up to 620 MPa (90 ksi).

**PROPERTIES** Excelent weld puddle manipulation and overal welding properties with extreme low hydrogen content (below 3 ml/100 gr. weld metal). Due to the addition of molybdenium suitable for post weld heat treatment respecting the impact properties.

**CLASSIFICATION**

AWS	A 5.29: E101T1-K3M H4
EN ISO	18276-A: T 62 4 1,5NiMo P M21 1 H5
F-nr	6
FM	2

**SUITABLE FOR**

**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

**APPROVALS** CE

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

C	Mn	Si	P	S	Ni	Mo
0.08	1.4	0.5	0.015	0.015	1.7	0.3

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
				-20°C	-40°C	
As Welded	645	735	20	70	55	HRc

**REDRYING** Not required

**GAS ACC. EN ISO 14175** M21