



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 molybdenum 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	PAPBPCPDPEPFPG						
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 _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	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						