CEWELD AA R690

certilas® THE FILLER METAL SPECIALIST

TYPE

Seamless rutile flux-cored welding wire for high strength S690-HY100 steels.(E111T1, T 69 6 Z P)

APPLICATIONS

CEWELD® AA R690 is one of the first seamless rutile FCWs with extremely low hydrogen content for S690 steels.
Main areas of application are in:
Shipbuilding, steel and tank construction, mechanical engineering and pipeline construction, offshore, crane construction, lifting equipment, platforms. Steels with a yield strength of up to 690 MPa (100 ksi).

PROPERTIES

CEWELD® AA R690 is ideal for positional welding where a high deposition rate is required and can withstand temperatures down to -60 °C (with offshore approval down to -40 °C). It is ideal for use on ceramic substrates and MAG orbital welding in all positions. It is characterised by extremely low-spatter properties and excellent arc stability with rapidly solidifying slag. Please note that all quality values are dependent on adherence to the correct t8/5 time.

CLASSIFICATION

AWS	A 5.29: E 111T1-GM-J H4, A 5.36: E111T1-M21A4-G-H4
EN ISO	18276-A: T 69 6 Z P M21 1 H5
F-nr	6
FM	2

SUITABLE FOR

Reh < 690 MPa Iso 15608: 2.2 u 3.2 (460 < Reh ≤ 690(700) MPa)
1.8914, 1.8927, 1.8931, 1.8928, 1.8974, 1.7147, 1.7149, 1.8734
S620Q, S620QL, S690Q, S690QL, S620QL1-S690QL1, 20MnCr65, 28CrMn4-3
L480 - L550, X65, X80, X90, X100
ASTM A 514 Gr. F, H, Q; A 709 Gr. 100 Type B, E, F, H, Q; A 709 Gr. HPS 100W
Weldox 700, Dillimax 690, Hardox, Naxtra 63, Naxtra 70, Optim 700 mc plus, Weldox 500, Hardox, Domex 460 MC, Domex 500 MC, Domex 550 MC, Domex 600 MC, Domex 650 MC, Domex 700 MC, Hardox 400,Strenx 700; XAR 400, Dillidur 400, Oceanfit 100, Oceanfit 690, alform plate 620 M, 700 M, aldur 620 Q, 620 QL, 620 QL1, aldur 700 Q, 700 QL, 700 QL1, Salzgitter S700MC, Ympress Steel E690 TM, S700MC, Amstrong Ultra 650MC, 650 MCt, 700 MC.....

APPROVALS

CE, Lloyds, DNV

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Cr	Ni	Mo
0.06	0.4	1.6	0.015	0.015	0.3	2.2	0.3

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				-40°C	-60°C	
As Welded	705	850	20	75	50	HRc

REDRYING

Not required

GAS ACC. EN ISO 14175

M21

CEWELD AA R690

AA R690 1,2MM

Packaging	KG/unit	EanCode
BS-300	16	8720663423733
D-200	20 (4x5)	8720663423726