



CEWELD AA M500

TYPE Seamless metal cored wire without slag for M21. (E80C-Ni1, T 50 6 .. Ni1)

APPLICATIONS CEWELD® AA M500 meets the latest offshore requirements for sub-zero temperatures down to -60°C. The wire is suitable for steel grades up to 500 MPa yield strength (such as S500).
In the areas of: Cranes, heavy transport, platforms, ships and lifting equipment in the offshore sector, pipelines and applications that must fulfil NACE requirements (less than 1% nickel).

PROPERTIES CEWELD® AA M500 is a unique filler metal with less than 1% nickel that fully complies with NACE requirements and covers a wider range of applications up to steels with a yield strength of 500 MPa. CEWELD® AA M500 can also be used for constructions requiring post-weld heat treatment and still provide mechanical properties confirming class 5Y46. Due to the seamless manufacturing process, the hydrogen content is below 3 ml/100 g of weld metal even after prolonged storage in the unconditioned state.

CLASSIFICATION

AWS	A 5.28: E80C-Ni1 H4, A 5.36: E81T15-M21A8-Ni1-H4
EN ISO	17632-A: T 50 6 1Ni M M21 1 H5
F-nr	6
FM	1

SUITABLE FOR **Reh ≤ 500 MPa ISO 15608: 1.3, ~3.1, ~2.2, 2.1,**
1.8900, 1.8901, 1.8902, 1.8903, 1.8905, 1.8907, 1.8910, 1.8912, 1.8915, 1.8917, 1.8930, 1.8932, 1.8935, 1.8937, 1.8970, 1.8971, 1.8972, 1.8973, 1.8975
S460N, S420N, S460NL, P460N, StE 420, StE 460, StE 500, TStE 380, S420NL, P460NL1, P420NH, P460NH, TStE 420, TStE 460, TStE 500, WStE 380, WStE 420, WStE 460, WStE 500, StE 385.7, StE 385.7 TM, StE 415, L485ME
ASTM A 203 Gr. D, E; A 350 Gr. LF1, LF2, LF3; A 420 Gr. WPL3, WPL6; A 516 Gr. 60, 65, 70; A 572 Gr. 42, 50, 55, 60, 65; A 633 Gr. A, D, E; A 662 Gr. A, B, C; A 707 Gr. L1, L2, L3; A 738 Gr. A; A 841 A, B, C; API 5 L X52, X60, X65, X52Q, X60Q, X65Q
Oceanfit 52, Oceanfit 60, Oceanfit 65, Oceanfit 355, Oceanfit 420, Oceanfit 460, alform plate 460M; durostat 400, 450, 500, durostat B2

APPROVALS CE, DNV

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

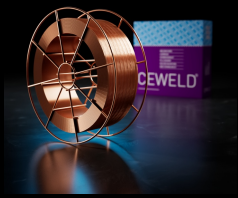
C	Si	Mn	P	S	Ni
0.05	0.7	1.5	0.015	0.015	0.9

MECHANICAL PROPERTIES

Heat Treatment	Rp0,2 (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				-40°C	-60°C	
As Welded	550	690	26	80	60	HRc

REDRYING Not required

GAS ACC. EN ISO 14175 M21



CEWELD AA M500

AA M500 1,2MM

Packaging	KG/unit	EanCode
BS-300	16	8720663423405