
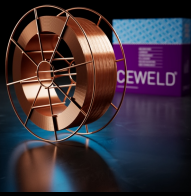


CEWELD AA R500

| TYPE | Fil fourré tubulaire cuivré Rutile 1% Nickel pour le soudage des aciers S460 et X70 | | | | | | | | | | | | | | | | |
|--------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|-------------|----------|--------|-------------------------|--------|----------|-------------------------|-------|-----------|-------|-----|----|----|----|-----|
| APPLICATIONS | Offshore, construction navale, appareils à pression, tuyauterie orbitale. | | | | | | | | | | | | | | | | |
| PROPRIÉTÉS | CEWELD® AA R500 est un fil fourré rutile tubulaire cuivré qui offre une excellente capacité de modelage et convient donc parfaitement au soudage en position à des courants élevés. Le dépôt de soudure présente des propriétés d'impact fiables jusqu'à -60°C. Particulièrement adapté au soudage orbital MAG et au soudage sur latte céramique dans toutes les positions. CTOD testé à -20°C. Teneur en hydrogène diffusible extrêmement faible (en moyenne inférieure à 3ml/100g). | | | | | | | | | | | | | | | | |
| CLASSIFICATION | AWS A 5.29: E81T1-Ni1M-J H4, A 5.36: E81T1-M21A8-Ni1-H4 EN ISO 17632-A: T 50 6 1Ni P M21 1 H5, 17632-A: T 46 4 1Ni P C1 1 H5 F-nr 6 FM 1 | | | | | | | | | | | | | | | | |
| CONVIENT POUR | ReH ≤ 500 MPa ISO 15608: 1.1, 1.3, 2.1, 2.2 (ReH max. 500 MPa), 3.1 (ReH max. 500 MPa) 1.0580 to 1.0070, 1.8900 to 1.8905, 1.8930 to 1.8935, 1.8910 to 1.8915, 1.6217, 1.6210, 1.0481, 1.0482, 1.0551, 1.0553. S275N-S460N, S275NL-S460NL, S275M-S460M, S275ML-S460ML, P355N, P355NH, P460N, P460NH, P275NL1-P460NL1, P275NL2- P460NL2, L360NB, L415NB, L360MB-L450MB, L360QB-L450QB 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, X70Q Oceanfit 52, Oceanfit 60, Oceanfit 65, Oceanfit 355, Oceanfit 420, Oceanfit 460, alform plate 460M; durostat 400, 450, 500, durostat B2, aldur 500Q, aldur 500QL, aldur 500QL1, N-A-XTRA 56 | | | | | | | | | | | | | | | | |
| AGRÈMENTS | TÜV: (12705), CE, Lloyds, DNV | | | | | | | | | | | | | | | | |
| POSITIONS DE SOUDAGE |  | | | | | | | | | | | | | | | | |
| ANALYSE CHIMIQUE TYPIQUE DU MÉTAL DE SOUDURE (%) | <table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td style="width: 16.6%;">C</td> <td style="width: 16.6%;">Si</td> <td style="width: 16.6%;">Mn</td> <td style="width: 16.6%;">P</td> <td style="width: 16.6%;">S</td> <td style="width: 16.6%;">Ni</td> </tr> <tr> <td>0.08</td> <td>0.5</td> <td>1.4</td> <td>0.015</td> <td>0.015</td> <td>0.9</td> </tr> </table> | C | Si | Mn | P | S | Ni | 0.08 | 0.5 | 1.4 | 0.015 | 0.015 | 0.9 | | | | |
| C | Si | Mn | P | S | Ni | | | | | | | | | | | | |
| 0.08 | 0.5 | 1.4 | 0.015 | 0.015 | 0.9 | | | | | | | | | | | | |
| PROPRIÉTÉS MÉCANIQUES | <table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">Rp0,2 (MPa)</th> <th rowspan="2">Rm (MPa)</th> <th rowspan="2">A5 (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th>-60°C</th> <th>-40°C</th> </tr> <tr> <td>As Welded</td> <td>550</td> <td>600</td> <td>24</td> <td>80</td> <td>90</td> <td>HRc</td> </tr> </table> | Heat Treatment | Rp0,2 (MPa) | Rm (MPa) | A5 (%) | Impact Energy (J) ISO-V | | Hardness | -60°C | -40°C | As Welded | 550 | 600 | 24 | 80 | 90 | HRc |
| Heat Treatment | Rp0,2 (MPa) | | | | | Rm (MPa) | A5 (%) | | Impact Energy (J) ISO-V | | Hardness | | | | | | |
| | | -60°C | -40°C | | | | | | | | | | | | | | |
| As Welded | 550 | 600 | 24 | 80 | 90 | HRc | | | | | | | | | | | |
| ETUVAGE | Non requis | | | | | | | | | | | | | | | | |
| GAS ACC. EN ISO 14175 | M21, C1 | | | | | | | | | | | | | | | | |



CEWELD AA R500

AA R500 1,2MM

| Packaging | KG/unit | EanCode |
|-----------|----------|---------------|
| BS-300 | 16 | 8720663423672 |
| D-200 | 20 (4x5) | 8720663423658 |
| Drum | 250 | 8720663423665 |

AA R500 1,6MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| BS-300 | 16 | 8720682051627 |