

AA B500

CATEGORY	FCAW Flux-Cored
TYPE	Basic seamless micro alloyed flux cored welding wire
APPLICATIONS	Pressure vessels, steam boilers, riser pipes, low temperature requirements, high demanding and stressed constructions that needs post weld heat treatment.
PROPERTIES	High basic seamless fluxcored welding wire for extreme offshore requirements at sub zero temperatures down to -80 degrees Celsius. Excelent welding properties and very low hydrogen content due to the seamless production proces.
CLASSIFICATION	AWS 5.29: E 90T5-K2M-J H4

SUITABLE FOR X80, P500QL2, P420, S460, AISI 4130, 8630 and similar grades that require yield strength above 500 N/mm² fulfilling NACE requirements in combination with high impact properties at extreme sub zero temperatures.

APPROVALS In progress, CE approved

WELDING POSITIONS:



TYPICAL WELD METAL WEIGHT %

C	Mn	Si	Cr	Ni	Cu	P	S
0,085	1.55	0,5	0,02	0,97	0,12	0,011	0,007

MECHANICAL PROPERTIES (TYPICAL)

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				-40°C	-60°C	-80°C	
AW	>500	>600	>23			>50	
PWHT 585°C / 2hr.	558	645	26	117	98	70	

AW: as welded / PWHT: post weld heat treatment

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A) (DC+)	spool type	kg / spool / drum	kg / pallet
1,2	23-32	230-290	D-200 / K-300 / drum	5 / 16 / 300	1000 / 1024 / 600

REDRYING TEMPERATURE not required

GAS ACC. EN ISO 14175: M21