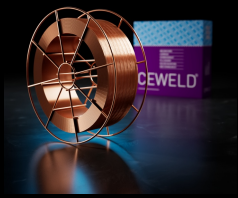




# CEWELD AA M610

|                                             |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                    |     |                         |                      |      |        |          |       |      |
|---------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------|-----|-------------------------|----------------------|------|--------|----------|-------|------|
| TYPE                                        | Seamless metal-powder cored wire without slag for M21                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                                    |     |                         |                      |      |        |          |       |      |
| APPLICATIONS                                | Steel construction, shipbuilding, pressure vessels, mechanical engineering, pipe work, offshore, crane building, heavy transport, lifting equipment respecting the NACE requirements.                                                                                                                                                                                                                                                                                                                                                                                                                            |                                    |     |                         |                      |      |        |          |       |      |
| PROPERTIES                                  | Seamless metal cored wire with remarkable stable arc and no spatters. Excelent for use in automated welding applications such as orbital Mag or robotic welding.This wire offers a unique covering range that anables you to use only one wire to cover more procedures upto 620N/mm2 yield strenght steels. AA M610 can also be used for constructions that needs post weld heat treatment after welding and still offers excellent impact properties. Due to the seamless production process the hydrogen content is below 3ml/100gr weld metal even after long storage.                                       |                                    |     |                         |                      |      |        |          |       |      |
| CLASSIFICATION                              | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | A 5.28: E100C-K3 H4                |     |                         |                      |      |        |          |       |      |
|                                             | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | 18276-A: T 62 6 Mn1NiMo M M21 1 H5 |     |                         |                      |      |        |          |       |      |
|                                             | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | 6                                  |     |                         |                      |      |        |          |       |      |
|                                             | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | 2                                  |     |                         |                      |      |        |          |       |      |
| SUITABLE FOR                                | <b>Reh &lt; 6200 MPa Iso 15608: ~3.2 ( 460 &lt; Reh ≤ 690 MPa)</b><br>S620Q, S620QL, S620QL1-S620QL1, 20MnCr65, 28CrMn43<br>L480 - L550, X65, X80, X90<br>ASTM A 514 Gr. F, H, Q; A 709 Gr. 100 Type B, E, F, H, Q; A 709 Gr. HPS 100W<br>Weldox 600, Dillimax, S690QL1, Hardox, Naxtra 63, Naxtra 70, Optim 600 mc plus, Weldox 500, Hardox, Domex 460 MC, Domex 500 MC, Domex 550 MC, Domex 600 MC, Domex 650 MC, Domex 600 MC, Hardox 400, XAR 400, Dillidur 400, Oceanfit 100, Oceanfit 600, alform plate 620 M, aldur 620 Q, 620 QL, 620 QL1,                                                               |                                    |     |                         |                      |      |        |          |       |      |
| APPROVALS                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                    |     |                         |                      |      |        |          |       |      |
| WELDING POSITIONS                           | <div></div> |                                    |     |                         |                      |      |        |          |       |      |
| TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | Si                                 | Mn  | P                       | S                    | Cr   | Ni     | Mo       | V     | Cu   |
|                                             | 0.06                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | 0.6                                | 1.7 | 0.007                   | 0.014                | 0.03 | 0.93   | 0.46     | 0.001 | 0.07 |
| MECHANICAL PROPERTIES                       | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                    |     | R <sub>p0,2</sub> (MPa) | R <sub>m</sub> (MPa) |      | A5 (%) | Hardness |       |      |
|                                             | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                    |     | 634                     | 711                  |      | 25     | HRc      |       |      |
| REDRYING                                    | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                    |     |                         |                      |      |        |          |       |      |
| GAS ACC. EN ISO 14175                       | M21                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                    |     |                         |                      |      |        |          |       |      |



# CEWELD AA M610

AA M610 1,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| K-300     | 16      | 8720663423443 |