




CEWELD AA B350

TYPE	Seamless high basic flux core wire for Ar-CO2 mix						
APPLICATIONS	Pipe work, shipbuilding, steel and vessel construction, mechanical engineering.						
PROPERTIES	Extremely crack resistant weld metal conditioned by the basic slag. Low spatter loss, easy slag removal. Well suited for joining high carbon steels and when welding critical mixed base metal combinations. Ideal metallurgical choice for repair welding and production as well as for use as a buffer layer. Developed for repair welding of pipes using half shells						
CLASSIFICATION	AWS	A 5.20: E61T-G					
	EN ISO	17632-A: T 35 4 B M 1 H5					
	F-nr	6					
	FM	1					
SUITABLE FOR	Reh ≤ 350 MPa ISO 15608: 1.1, 1.2 1.0033, 1.0035, 1.0340, 1.0112, ...1.0426, 1.0473...1.0570 E155, S185, S235..S355, P235... P355 ASTM A284 Gr. C, D, A 830 M, A 516 M, A 299 M, A 573 M UNS G10220, SAE 1022 Armco Steels, Telar 75						
APPROVALS	CE						
WELDING POSITIONS							
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S		
	0.04	0.6	1.2	0.015	0.015		
MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
	As Welded	350	500	27	-20°C	-40°C	HRC
					100	80	
REDRYING	Not required						
GAS ACC. EN ISO 14175	M21						