



CEWELD AA M960

TYPE	Seamless metal cored wire without slag for M21 with extreme yield strength.								
APPLICATIONS	Crane, steel, lifting, vessel and apparatus construction.								
PROPERTIES	Good arc restriking, suitable for robot applications. Usable in the field short arc and spray arc. Excellent gap bridging for root welding. High-efficiency type for economic production of high-strength fine-grain structural steels up to 1100 MPa Yield Strength. Stable mechanical property values up to heat input of 10 kJ/cm. Due to the seamless production process the hydrogen content is below 3ml/100gr weld metal even after long storage in unconditioned condition.								
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.28: E110C-K4 H4</td> </tr> <tr> <td>EN ISO</td> <td>18276-A: T 89 4 ZMn2NiCrMo M M21 1 H5</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>2</td> </tr> </table>	AWS	A 5.28: E110C-K4 H4	EN ISO	18276-A: T 89 4 ZMn2NiCrMo M M21 1 H5	F-nr	6	FM	2
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EN ISO	18276-A: T 89 4 ZMn2NiCrMo M M21 1 H5								
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SUITABLE FOR	<p>Reh ≤ 960 MPa ISO 15608: ~3.1, 3.2 (Reh > 690 MPa) 1.8796, 1.8925, 1.8940, 1.8983, 1.8797, 1.8933, 1.8934, 1.8941, 1.8997 S690Q-S890Q, S690QL-S890QL, S960Q, S960QL, S720MC ASTM A 709 Gr. 100 Type B, E, F, H, Q, HPS 100W N-A-XTRA M 700, PAS 700, alform 700 M, alform 900 x-treme, alform® 960 x-treme, Strenx 700-960, DILLIMAX 700-960</p>
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APPROVALS	CE
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WELDING POSITIONS	
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TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S	Cr	Ni	Mo
	0.05	0.4	1.6	0.015	0.015	0.5	2.6	0.6

MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V	Hardness
					-40°C	
	As Welded	960	1050	17	55	HRc

REDRYING	Not required
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GAS ACC. EN ISO 14175	M21
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CEWELD AA M960

AA M960 1,2MM

Packaging	KG/unit	EanCode
K-300	16	8720663423481