



CEWELD AA M690

TYPE Seamless metal cored MCAW welding wire for S690 - HY100

APPLICATIONS Crane-, plant-, craft-, lifting and steel construction, pipe work, foundries.

PROPERTIES Remarkable crack resistant weld metal in combination with very low (<3ml/100gr) hydrogen content. Therefore, suitable for the economic processing of high-strength up to 690 MPa and low temperature fine grained structural steels. Excellent welding properties in short and spray arc. High deposition rate and no intermediate cleaning required with very low spatter loss. Excellent wetting properties compare to solid wires that results in a bigger parameter range and improved duty cycle for the welder.

CLASSIFICATION

AWS	A 5.28: E110C-K4 H4
EN ISO	18276-A: T 69 6 Mn2NiCrMo M M21 1 H5
F-nr	6
FM	2

SUITABLE FOR Reh < 690 MPa Iso 15608: 2.2 u 3.2 (460 < Reh ≤ 690(700) MPa)
 1.8914, 1.8927, 1.8931, 1.8928, 1.8974, 1.7147, 1.7149, 1.8734
 S620Q, S620QL, S690Q, S690QL, S620QL1-S690QL1, 20MnCr65, 28CrMn4-3
 L480 - L550, X65, X80, X90, X100
 ASTM A 514 Gr. F, H, Q; A 709 Gr. 100 Type B, E, F, H, Q; A 709 Gr. HPS 100W
 Weldox 700, Dillimax 690, Hardox, Naxtra 63, Naxtra 70, Optim 700 mc plus, Weldox 500, Hardox,
 Domex 460 MC, Domex 500 MC, Domex 550 MC, Domex 600 MC, Domex 650 MC, Domex 700 MC,
 Hardox 400, Strenx 700; XAR 400, Dillidur 400, Oceanfit 100, Oceanfit 690, alform plate 620 M, 700 M,
 aldur 620 Q, 620 QL, 620 QL1, aldur 700 Q, 700 QL, 700 QL1, Salzgitter S700MC, Ympress Steel E690
 TM, S700MC, Armstrong Ultra 650MC, 650 Mct, 700 MC.....

APPROVALS TÜV: 12707.01, CE, Lloyds, DNV

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

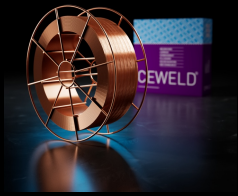
C	Si	Mn	P	S	Cr	Ni	Mo
0.05	0.4	1.6	0.015	0.015	0.5	2.2	0.5

MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				-40°C	-60°C	
As Welded	763	820	20	140	107	HRc
570°C- 620°C 1h	730	790	22	99	94	HRc

REDRYING Not required

GAS ACC. EN ISO 14175 M21



CEWELD AA M690

AA M690 1,0MM

Packaging	KG/unit	EanCode
K-300	16	8720663423467

AA M690 1,2MM

Packaging	KG/unit	EanCode
BS-300	16	8720663423474
D-200	5	8720663423450

AA M690 1,6MM

Packaging	KG/unit	EanCode
K-300	16	8720663408181