certilas® THE FILLER METAL SPECIALIST

CEWELD AA B690

TYPE	Seamless, high-strength flux-cored wire for M21 with basic slag
APPLICATIONS	Crane-, plant-, craft- and steel construction, pipe work, foundries
PROPERTIES	Absolutely crack resistant weld metal conditioned by the high-basic slag in combination with extreme low hydrogen content. Therefore, suitable for the economic processing of high-strength, low temperature fine-grained structural steels with Rp0,2 > 690 MPa. X-ray-proof seams with low spatter loss. Stable, mechanical property values of the weld metal also at high heat input up to 18 kJ/cm.

CLASSIFICATION

AWS	A 5.29: E110T5-K4M H4
AWS	A 5.36: E110T5-M21A8-K4-H4
EN ISO	18276-A: T 69 6 Mn2NiCrMo B M21 3 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, Amstrong Ultra 650MC, 650 MCt, 700 MC.....

APPROVALS: CE

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

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Impact Energy (J) ISO-V -40°C	-60°C
As Welded /	740	850	19	85	75
570°C- 620°C /1h	650	740	22	80	55

REDRYING TEMPERATURE: Not required

GAS ACCORDING EN 14175: M21

CEWELD AA B690

AA B690 1,2MM

Type	KG/unit	EANCode
D-200	20 (4x5)	8720663423160
K-300	16	8720663423177