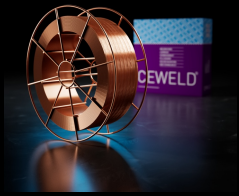




# CEWELD AA M960

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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FM	2																
SUITABLE FOR	<p><b>Reh ≤ 960 MPa ISO 15608: ~3.1, 3.2 (Reh &gt; 690 MPa)</b>            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>																
APPROVALS	CE																
WELDING POSITIONS																	
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> </tr> </thead> <tbody> <tr> <td>0.05</td> <td>0.4</td> <td>1.6</td> <td>0.015</td> <td>0.015</td> <td>0.5</td> <td>2.6</td> <td>0.6</td> </tr> </tbody> </table>	C	Si	Mn	P	S	Cr	Ni	Mo	0.05	0.4	1.6	0.015	0.015	0.5	2.6	0.6
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	MPa	MPa	(%)														
As Welded /	960	1050	17	55													
REDRYING TEMPERATURE	Not required																
GAS ACCORDING EN 14175	M21																



# CEWELD AA M960

AA M960 1,2MM

Type	KG/unit	EANCode
K-300	16	8720663423481