





TYPE Seamless metal flux cored wire for gas metal arc welding of high-strength steels up to a minimum

yield strength of 960 (1100) MPa. (Type T 89 4 Zmn2NiCrMo, E 120C-G) Mn2NiCrMo, E 110C-K4)

APPLICATIONS CEWELD® AA M960 offers a unique weld metal for steels up to 890 MPa yield strength.

Areas of application are:

Crane-, plant-, craft-, lifting and steel construction, pipe work, foundries, ship building, offshore

applications and also for penstocks.

PROPERTIES CEWELD® AA M960 has good arc ignition and is suitable for robot applications. The arc range

extends from short arc to spray arc. CEWELD® AA M960 has excellent gap bridging properties for root pass welding. It is a high-performance grade for the economical processing of high-strength fine-grain structural steels up to 1100 MPa yield strength while maintaining the T8/5 time. Thanks to the seamless production process, the hydrogen content is below 3 ml/100 g of weld metal even

after prolonged storage.

CLASSIFICATION AWS A 5.28: E110C-K4 H4

EN ISO 18276-A: T 89 4 ZMn2NiCrMo M M21 1 H5

F-nr 6 FM 2

SUITABLE FOR Reh ≤ 960 (1100) 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

APPROVALS CE

**WELDING POSITIONS** 



TYPICAL CHEMICAL ANALYSIS OF WELD METAL

ANALYSIS OF WELD METAL
(%)

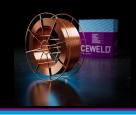
С	Si	Mn	Р	S	Cr	Ni	Мо
0.05	0.4	1.6	0.015	0.015	0.5	2.6	0.6

ALL WELD MECHANICAL PROPERTIES

Heat	R <sub>P0,2</sub>	Rm	A5	Impact Energy (J) ISO-V
Treatment	MPa	MPa	(%)	-40°C
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