



CEWELD AA B960

TYPE Medium alloyed, high-strength flux-cored wire for M21 shielding gas

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

PROPERTIES AA B960 is a seamless high basic flux cored wire that offers a absolute crack resistant weld metal conditioned by the high-basic slag. Therefore, suitable for the economic processing of high-strength, low temperature fine-grained structural steels with Yield strength >960 MPa. X-ray-proof weld deposit with low spatter loss. Stable mechanical properties of the weld metal also at high heat input up to E<18 kJ/cm. Low hydrogen content HD< 3 ml/100g even after long storage.

CLASSIFICATION

| | |
|--------|--------------------------------------|
| AWS | A 5.29: E120T5-K4M H4 |
| AWS | A 5.36: E110T5-M21A8-K4-H4 |
| EN ISO | 18276-A: T 89 4 Mn2NiCrMo B M21 3 H5 |
| F-nr | 6 |
| FM | 4 |

SUITABLE FOR 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

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 | R _m MPa | A5 (%) | Impact Energy (J) ISO-V -40°C |
|--------------------------------|----------------|-----------------------|--------------------|--------|-------------------------------|
| | As Welded /1h | 960 | 1010 | 17 | 55 |

REDRYING TEMPERATURE Not required

GAS ACCORDING EN 14175 M21