



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

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 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	2.6	0.6

MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V	Hardness
					-40°C	
	As Welded	960	1050	17	55	HRc

REDRYING Not required

GAS ACC. EN ISO 14175 M21



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AA M960 1,2MM

Packaging	KG/unit	EanCode
K-300	16	8720663423481