



# 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 <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
				-40°C		
As Welded	960	1050	17	55		HRc

**REDRYING** Not required

**GAS ACC. EN ISO 14175** M21



# CEWELD AA M960

AA M960 1,2MM

Packaging	KG/unit	EanCode
K-300	16	8720663423481