

## AA B890 SR

**CATEGORY** FCAW Flux-Cored

**TYPE** Medium alloyed, high-strength flux-cored wire for Argon-Co2 Mix.

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

**PROPERTIES** Remarkable crack resistant weld metal in combination with very low hydrogen content. Therefore, suitable for the economic processing of high-strength and low temperature fine-grained structural steels. Excellent welding properties in short and spray arc. Excellent gap bridging for root welds. High deposition rate and no intermediate cleaning required with very low spatter loss. Weld metal is heat treatable.

**CLASSIFICATION** AWS 5.28: E 120 C-K4 H4  
EN ISO 18276: T 89 4 Z M M 1 H5

**SUITABLE FOR** XABO 90, StE890V, weldox 700, weldox 900, StE960 TM, 42CrMo4, 1.7225, 1.8914  
**DIN** 25CrMo4, 34CrMo4, 42CrMo4, 28NiCrMo44, **till** StE 890 VA, till StE 890 (1.8979),  
**EN** 25CrMo4, 34CrMo4, 42CrMo4, 28NiCrMo44, **till** S890QL1  
Domex 650 MC, Domex 700 MC

**APPROVALS** CE approved

**WELDING POSITIONS:**



**WELD METAL ANALYSIS %**

C	Mn	Si	P	S	Cr	Ni	Mo
0.07	1.3	0.6	< 0.015	< 0.015	1.2	2.3	1.0

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				RT °C	-40°C	-60°C	
AW	> 890	980-1180	> 15	> 60			
SR	> 700	800-950	> 16	> 47			

AW: as welded, SR: stress relieved 580°C / 2hr.

**WELDING PARAMETERS / PACKING**

Welding Parameters				Packing	
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet
1.2	24-32	220-300	K 202	5	1000
1.2	24-32	220-300	K 300	15	1024
1.6	26-34	240-350	K 300	15	1024

**REDRYING TEMPERATURE** not required

**GAS ACC. EN ISO 14175:** M21