

AA M960

CATEGORY FCAW Flux-Cored

TYPE Seamless metal cored wire without slag for M21 with extreme yield strength.

APPLICATIONS Crane, steel, lifting, vessel and apparatus construction.

PROPERTIES Good arc striking, 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. 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	5.28: ~E 120 C-K4 H4, 5.28 M: E83C-K4 H4
EN ISO	18276-A: T 89 4 Mn2NiCrMo M M 1 H5

SUITABLE FOR XABO 90, StE890V, StE960TM, Weldox 700, weldox 900, StE 890, S890QL1, StE 960, S960QL1, S1100 (till 12 mm)
ASTM: A 517, X120

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL DEPOSIT UNDER M21

C	Mn	Si	Cr	Ni	Mo	P	S
0.07	1.5	0.5	0.55	2.7	0.6	<0.015	<0.015

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
				-20°C	-40°C	-60°C	
AW	>960	980-1180	>14	>55	>47		

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A) DC+	spool type	kg / spool / Drum	kg / pallet
1,2	14-29	90-300	D-200 / K-300 / Drum	5 / 16 / 300	1000 / 1024 / 600

REDRYING TEMPERATURE Not required

GAS ACC. EN ISO 14175: M21