


## 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 <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A5 (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
	AW	>960	980-1180	>14	-20°C	-40°C	-60°C	
					>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							