

CATEGORY FCAW Flux-Cored

TYPE Medium alloyed, high-strength flux-cored wire for M21 shielding gas

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

PROPERTIES AA B960 is a seamless high basic flux cored wire that offers a absolute crack resistant weld metal conditioned by the high-basic slag. Therefore, suitable for the economic processing of high-strength, low temperature fine-grained structural steels with Yield strength >960 MPa. X-ray-proof weld deposit with low spatter loss. Stable mechanical properties of the weld metal also at high heat input up to E<18 kJ/cm. Low hydrogen content HD< 3 ml/100g even after long storage.

CLASSIFICATION

AWS	A 5.29: E120T5-K4M H4
AWS	A 5.36: E110T5-M21A8-K4-H4
EN ISO	18276-A: T 89 4 Mn2NiCrMo B M21 3 H5
F-nr	6
FM	4

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	2.2	0.5

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V -40°C
As Welded /1h	960	1010	17	55

WELDING PARAMETERS / PACKING

REDRYING TEMPERATURE Not required

GAS ACCORDING EN 14175 M21