



# CEWELD AA M960

**TYPE** Seamless metal flux cored wire for gas metal arc welding of high-strength steels up to a minimum yield strength of 960 (1100) MPa. (Type T 89 4 Zmn2NiCrMo, E 120C-G) Mn2NiCrMo, E 110C-K4)

**APPLICATIONS** CEWELD® AA M960 offers a unique weld metal for steels up to 890 MPa yield strength.

Areas of application are:

Crane-, plant-, craft-, lifting and steel construction, pipe work, foundries, ship building, offshore applications and also for penstocks.

**PROPERTIES** CEWELD® AA M960 has good arc ignition and is suitable for robot applications. The arc range extends from short arc to spray arc. CEWELD® AA M960 has excellent gap bridging properties for root pass welding. It is a high-performance grade for the economical processing of high-strength fine-grain structural steels up to 1100 MPa yield strength while maintaining the T8/5 time. Thanks to the seamless production process, the hydrogen content is below 3 ml/100 g of weld metal even after prolonged storage.

**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 (1100) MPa ISO 15608: ~3.1, 3.2 (Reh > 960 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)	A5 (%)	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