



CEWELD AA B890SR

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

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

PROPRIÉTÉS 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. Exelent welding properties in short and spray arc. Excelent gab bridging for root welds. High deposition rate and no intermediate cleaning required with very low spatter loss. Weld metal is heat treatable.

CLASSIFICATION

AWS	A 5.36: E130T5-M21A4-K4-H4
EN ISO	18276-A: T 89 0 Z B M21 3 H5
F-nr	6
FM	4

CONVIENT POUR **Reh ≤ 890 MPa ISO 15608: 5.1**
1.7220, 1.7225, 1.7228, 1.7336
13 CrMoSi5-5, 13CrMo4-5, 25CrMo4, 26 CrMo4-2, 34CrMo4, 42CrMo4, 50CrMoSi5-5, 28NiCrMo44,
(S690Q-S890Q, S690QL-S890QL)
ASTM A 829M, A387, SAE 4135-37, 4140-45, 4150
UNS G41350-70, G41400-50, G41500
40CD4, 42CD4 / 40CD4u, 42CD4u
Firmodur 7225, 7227., Thyssen TK 7225, 7227

AGRÉMENTS CE

POSITIONS DE SOUDAGE



ANALYSE CHIMIQUE
TYPIQUE DU MÉTAL DE
SOUDURE (%)

C	Si	Mn	P	S	Cr	Ni	Mo
0.05	0.5	1.5	0.015	0.015	0.5	2.2	0.5

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V	Hardness
				RT	
As Welded	920	1010	17	75	HRc
620°C±15°C 1h	710	910	18	55	HRc

ETUVAGE Not required

GAS ACC. EN ISO 14175 M21