



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.

PROPERTIES 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

SUITABLE FOR **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

APPROVALS CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

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

MECHANICAL PROPERTIES

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

REDRYING Not required

GAS ACC. EN ISO 14175 M21