



# 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. Excellent welding properties in short and spray arc. Excellent gap 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	<b>Reh ≤ 890 MPa ISO 15608: 5.1</b> 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 <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	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							