



# 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 <sub>P0.2</sub><br>(MPa) | R <sub>m</sub><br>(MPa) | A <sub>5</sub><br>(%) | 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