BÖHLER Kb 90 T-FD

Flux cored wire, seamless, high strength, basic type

Classifications

EN ISO 18276-A	AWS A5.29
T89 4 Mn2Ni1CrMo B M 3 H5	E120T5-GM-H4

Characteristics and typical fields of application

Seamless basic flux cored wire for welding of very high strength Nickel-Chromium-Molybdenum alloyed steels with Ar-CO_2 shielding gas.

Features include: excellent weldability in flat and horizontal positions, smooth and bright bead, less spatter, easy to remove slag and very high mechanical properties at low temperatures.

Base materials

S690Q-S890Q, S690QL-S890QL, S960Q, S960QL, N-A-XTRA M 700, PAS 700, alform 700 M, alform 900 x-treme, alform 960 x-treme

ASTM A 709 Gr. 100 Type B, E, F, H, Q, HPS 100W

Typical analysis of all-weld metal (wt.-%)

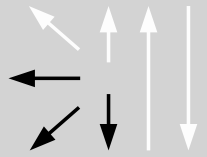
	Gas	C	Si	Mn	Ni	Cr	Mo
wt-%	M21	0.06	0.40	1.40	2.20	0.40	0.40

Mechanical properties of all-weld metal

Condition	Yield strength $R_{p0.2}$	Tensile strength R_m	Elongation A (L_0=5d_0)	Impact work ISO-V KV J
	MPa	MPa	%	-40°C
u	**960** (≥890)	**1010** (940–1180)	**19** (≥15)	**75** (≥47)

u untreated, as welded – shielding gas M21

Operating data



Polarity:	Shielding gas:	ø (mm)
DC (+)	(EN ISO 14175) M21	1.2

Welding with standard GMAW-facilities possible

Approvals

CE