# BÖHLER Kb 90 T-FD

Flux cored wire, seamless, high strength, basic type

## Classifications

| EN ISO 18276-A | AWS A5.36 |
|---|---|
| T89 4 Mn2Ni1CrMo B M21 3 H5 | E130T5-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.-%)

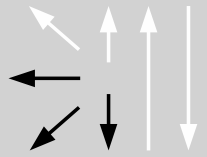
| | Gas | C | Si | Mn | Ni | Cr | Mo |
|---|---|---|---|---|---|---|---|
| wt-% | M21 | 0.06 | 0.40 | 1.40 | 2.20 | 0.40 | 0.40 |

## Mechanical properties of all-weld metal

| Condition | Yield strength $R_{p0.2}$ | Tensile strength $R_m$ | Elongation A ($L_0$=5$d_0$) | 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 power source possible

## Approvals

CE