

# CARBOFIL TENSIMAX 89

## TOP FEATURES

- Optimized for ultra-high strength steel up to 1110 MPa and beyond
- Suited for critical loadbearing applications
- Offers superior mechanical properties and impact resistance

## TYPICAL APPLICATIONS

- Mobile cranes
- High-strength and wear-resistant machinery
- Earthmoving equipment
- Defense technology
- Recycling machines

## CLASSIFICATION

AWS A5.28 ER1205-G  
EN ISO 16834-A G 89 6 M21 Mn4Ni2CrMo

## APPROVALS

CE

## SHIELDING GASES (ACC. EN ISO 14175)

M21 Mixed gas Ar+ 15-25% CO<sub>2</sub>

## CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, WIRE

C	Mn	Si	P	S	Ni	Cr	Mo
0.09	1.8	0.80	0.010	0.011	2.20	0.35	0.55

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	Yield strength (MPa)	Tensile strength (MPa)	Elongation		Impact ISO-V (J) -60°C
					4d (%)	5d (%)	
Typical values	M21	AW	900	950	17	15	60

AW = As welded

## AVAILABLE SIZES AND PACKAGING INFORMATION

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.0	SPOOL (BS300)	16.0	580611
1.2	SPOOL (BS300)	16.0	580612

## TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing. Please refer to [www.lincolnelectric.eu](http://www.lincolnelectric.eu) for any updated information.