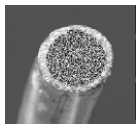
Seamless flux-cored wire for MAG joint welding

MEGAFIL® 713 R



Type: Micro-alloy rutile flux-cored wire with rapidly solidifying slag for CO_2 and Ar-CO_2 mix.

Applications: Shipbuilding, steel and vessel construction, mechanical engineering and pipe work.

Properties: Excellent weld puddle manipulation, superior out-of-position welding also at higher currents. Using temperature up to - 40 ℃ (- 40 ℉) .
Particularly suited for MAG-orbital welding and all-position welding on ceramic backing. Low spatter loss, easy slag removal.

Classification:

EN ISO 17632-A	T 46 4 P M 1 H5	T 46 2 P C 1 H5
EN ISO 17632-B	T554T1 1MA H5	T552T1 1CA H5
AWS ASME 5.20	E71T-1M-J H4	E71T-1C H4
	E71T-9M-J H4	E71T-9C H4
from Ø 1,6 mm on	E70T-9M-J H4	E70T-9C H4
	E71T-12M-J H4 *	E71T-12C-J H4 *
AWS ASME 5.20M	E491T-1M-J H4	E491T-1C H4
The ASME classification is carried out on the basis of a weld metal according to ISO standards	E491T-9M-J H4	E491T-9C H4
	E491T-12M-J H4 *	E491T-12M-J H4 *

* *Delivery upon agreement*

Materials:	**EN**	**ASTM**
shipbuilding steels	A, B, D, AH 32 - EH 36	typical A 258 / A 516 A 662 / A 387 A 738 / A 612 A 299
unalloyed structural steels	S185 - S355	
boiler steels	P235GH - P355GH	
pipe steels	P235T1/T2 - P460NL2 L210 - L445MB	
fine grain structural steels	S235 - S460QL1	
steels to API-standard	X 42 - X 60	

Approvals: TÜV, DB, GL, BV, LR, DNV, RINA, ABS, CWB

Weld metal analysis % (typical values for mixed gas M21 82% Ar / 18% CO_2)

C	Mn	Si	P	S
0,05	1,3	0,5	0,015	0,015

Mechanical properties of the pure weld metal (typical values)

PWHT	$R_{p0,2}$ MPa (ksi)	R_m MPa (ksi)	A5 %	Charpy V Notch [J] (ft.lb) - 20 ℃ (- 4 ℉) M21	- 20 ℃ (- 4 ℉) C1	- 40 ℃ (- 40 ℉) M21	- 40 ℃ (- 40 ℉) C1
AW	> 460 (67)	550 - 670 (80 - 97)	22	60 (44)	50 (37)	47 (35)	27 (20)

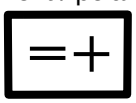
AW: as welded

Diameters: Ø 1,0 - 2,4 mm (0.04 - 3/32 inch)

Packaging: The same conditions as for solid wire.
Product should be stored in a dry, enclosed environment, and in its original intact packing

for detailed information please call us

current / polarity



welding position