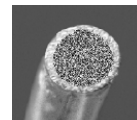




Seamless flux-cored wire

STEIN-MEGAFIL[®] 742 M



- Type:** Metal cored wire without slag for Ar-CO₂ mix.
- Applications:** Cranes, equipment, vessel and apparatus construction.
- Properties:** Good arc restriking even with cold wire tip, suitable for robot applications. Ideal for use of short arc and spray arc. Excellent gap bridging for root welding. High-efficiency type for economic production of high-strength fine grain structural steels. Stable mechanical property values of weld metal up to heat input of 15 kJ/cm.
- Classification:**
- | | |
|----------------|---------------------------|
| EN ISO 18276-A | T 69 6 Mn2NiCrMo M M 1 H5 |
| EN ISO 18276-B | T766T15 1MA N4C1M2 H5 |
| AWS ASME 5.28 | E110C-K4 H4 |
| AWS ASME 5.28M | E76C-K4 H4 |

Materials:	DIN	EN	ASTM
TM-pipe steels	up to StE 690.7 TM	up to L690M	typical A 517 / A 537
high-strength fine grain structural steels (tempered)	up to StE 690 V	up to S690QL	A 625 HY100 (16NiCrMo12-6)
high-strength fine grain structural steels (low temp)	up to EStE 690 VA	up to S690G1QL1	

Approvals: TÜV, LR, DNV, ABS, BV, GL, BWB-WIWEB

Weld metal analysis % (typical values for mixed gas M21 82% Ar / 18% CO₂)

C	Mn	Si	P	S	Cr	Ni	Mo
0,05	1,6	0,4	< 0,015	< 0,015	0,5	2,2	0,5

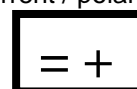
Mechanical properties of the pure weld metal (typical values for mixed gas)

Heat-treatment	R _{p0,2} MPa (ksi)	R _m MPa (ksi)	A5 %	Charpy V Notch [J] (ft.lb)	
				- 40 °C (- 40 °F)	- 60 °C (- 76 °F)
AW	> 690 (100)	770 - 940 (112 - 136)	> 17	> 75 (55)	> 69 (51)

AW: as welded

Diameters: Ø 1.0 - 1.6 mm (0.04 - 1/16 inch)
Packaging information: see chapter H

current / polarity



welding position

