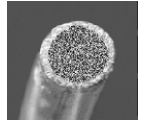




## Seamless flux-cored wire

# STEIN-MEGAFIL<sup>®</sup> 825 R



- Type:** Micro-alloy rutile flux-cored wire with rapidly solidifying slag for Ar-CO<sub>2</sub> mix.
- Applications:** Vessel and steel construction, mechanical engineering and pipe work.
- Properties:** Excellent weld puddle manipulation, superior out-of-position welding. Particularly suited for mechanized MAG welding and all-position welding on ceramic backing. High-efficiency type for economic production of Mo-steels up to 500 °C (932 °F). Low spatter loss, easy slag removal.
- Classification:**
- |                |                    |
|----------------|--------------------|
| EN ISO 17634-A | T Mo P M 1 H5      |
| EN ISO 17634-B | T55T1 1M 2M3 H5    |
| EN ISO 17632-A | T46 A Mo P M 1 H5  |
| EN ISO 17632-B | T55AT1 1MAP 2M3 H5 |
| AWS ASME 5.29  | E81T1-A1M H4       |
| AWS ASME 5.29M | E551T1-A1M H4      |

Materials:	DIN	EN	ASTM
boiler steels	HI, HII, 17Mn4, 19Mn5, 15Mo3, 16Mo3	P235GH - P355GH 16Mo3	typical A 204 Gr. A - C
pipe steels	St 35.8, St 45.8 StE 210.7 TM - StE 445.7 TM	P235T1/T2 - P460NL2 L210 - L445MB	
fine grain structural steels	StE 255 - StE 460	S255 - S460	

**Approvals:** TÜV

Weld metal analysis % (typical values for mixed gas M21 82% Ar / 18% CO<sub>2</sub>)

C	Mn	Si	P	S	Mo
0,05	1,1	0,5	< 0,015	< 0,015	0,5

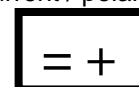
Mechanical properties of the pure weld metal (typical values for mixed gas)

Heat-treatment	R <sub>p0,2</sub> MPa (ksi)	R <sub>m</sub> MPa (ksi)	A5 %	Charpy V Notch [J] (ft.lb)		
				RT	0 °C (32 °F)	- 20 °C (- 4 °F)
AW and SR	> 470 (68)	550 - 680 (80 - 99)	> 22	> 60 (44)	> 47 (35)	> 27 (20)

AW: as welded SR: stress relief annealed 605 - 635 °C (1121-1175 °F) / 60 min

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

current / polarity



welding position

