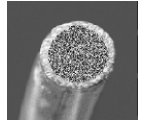




Seamless flux-cored wire

STEIN-MEGAFIL[®] 710 M



- Type:** Metal cored wire without slag for Ar-CO₂ mix.
- Applications:** Shipbuilding, steel and vessel construction, mechanical engineering and pipe work.
- 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.

- Classification:**
- | | |
|----------------|-----------------|
| EN ISO 17632-A | T 46 6 M M 1 H5 |
| EN ISO 17632-B | T556T15 1MAP H5 |
| AWS ASME 5.18 | E70C-6M H4 |
| AWS ASME 5.18M | E48C-6M H4 |

Materials:	DIN	EN	ASTM
shipbuilding steels	A, B, D, AH 32 - EH 36		typical
unalloyed structural steels	St 33, St 37-2 - St 52-3	S185 - S355	A 258 / A 516 A 662 / A 387
boiler steels	HI, HII, 17Mn4, 19Mn5	P235GH - P355GH	A 738 / A 612
pipe steels	St 35.8, St 45.8 StE 210.7 TM - StE 445.7 TM	P235T1/T2 - P460NL2 L210 - L445MB	A 299
fine grain structural steels	StE 255 - StE 460	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% CO₂)

C	Mn	Si	P	S
0,05	1,5	0,7	< 0,015	< 0,015

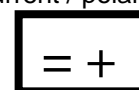
Mechanical properties of the pure weld metal (typical values for mixed gas)

Heat-treatment	R _{eL} MPa (ksi)	R _m MPa (ksi)	A5 %	Charpy V Notch [J] (ft.lb)	
				- 40 °C (- 40 °F)	- 60 °C (- 76 °F)
AW and SR	> 460 (67)	530 - 680 (77 - 99)	> 26	> 60 (44)	> 47 (35)

AW: as welded SR: stress relief annealed 580 - 620 °C (1076 °F - 1148 °F) / 60 min

- Diameters:** Ø 1,0 - 2,4 mm (0.04 - 3/32 inch)
- Packaging information:** see chapter H

current / polarity



welding position

