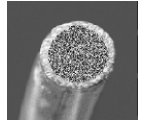




Seamless flux-cored wire

STEIN-MEGAFIL[®] 781 R



- Type:** Micro-alloy rutile flux-cored wire with rapidly solidifying slag for CO₂ and Ar-CO₂ mix.
- Applications:** Weather resistant steels. Cranes, equipment, vessel and apparatus construction.
- Properties:** Excellent weld puddle manipulation, superior out-of-position welding. Particularly suited for mechanized MAG welding and all-position welding on ceramic backing.
Low spatter loss, easy slag removal.

| | | |
|------------------------|----------------|-------------------|
| Classification: | EN ISO 17632-A | T 46 4 Z P M 1 H5 |
| | EN ISO 17632-B | T554T1 1MA G H5 |
| | AWS ASME 5.29 | E81T1-G H4 |
| | AWS ASME 5.29M | E551T1-G H4 |

| Materials: | DIN | EN | ASTM |
|---|--|------------------------------------|------------------------------------|
| weather resistant steels CuNi alloyed steels | WT St 37, WT St 52-3 StE 420 - 460 COR-TEN A,B,C Patinax 37 | S235JRW - S355JRW 9CrNiCuP3-2-4 | typical A 572 A 588 A 709 |
| fine grain structural steels | WStE 420 - StE 460 | S255 - S460 | |

Approvals: - - -

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

| C | Mn | Si | P | S | Ni | Cu |
|------|-----|-----|---------|---------|-----|-----|
| 0,05 | 1,3 | 0,5 | < 0,015 | < 0,015 | 1,1 | 0,5 |

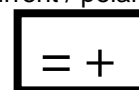
Mechanical properties of the pure weld metal (typical values for mixed gas)

| Heat-treatment | R _{eL} MPa (ksi) | R _m MPa (ksi) | A5 % | Charpy V Notch [J] (ft.lb) | |
|----------------|------------------------------|-----------------------------|---------|----------------------------|-------------------|
| | | | | - 20 °C (- 4 °F) | - 40 °C (- 40 °F) |
| AW | > 470 (68) | 550 - 680 (80 - 99) | > 22 | > 60 (44) | > 47 (35) |

AW: as welded

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

current / polarity



welding position

