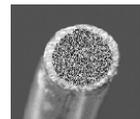




## Seamless flux-cored wire for MAG joint welding

# MEGAFIL<sup>®</sup> 713 R



**Type:** Micro-alloy rutile flux-cored wire with rapidly solidifying slag for CO<sub>2</sub> and Ar-CO<sub>2</sub> 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 °C (- 40 °F) .  
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
	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 *

from Ø 1,6 mm on

\* Delivery upon agreement

Materials:	EN	ASTM
shipbuilding steels	A, B, D, AH 32 - EH 36	typical
unalloyed structural steels	S185 - S355	A 258 / A 516
boiler steels	P235GH - P355GH	A 662 / A 387
pipe steels	P235T1/T2 - P460NL2 L210 - L445MB	A 738 / A 612
fine grain structural steels	S235 - S460QL1	A 299
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<sub>2</sub>)**

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 <sub>p0,2</sub> MPa (ksi)	R <sub>m</sub> MPa (ksi)	A5 %	Charpy V Notch [J] (ft.lb)			
				- 20 °C (- 4 °F)		- 40 °C (- 40 °F)	
				M21	C1	M21	C1
AW	> 460 (67)	550 - 670 (80 - 97)	22	60 (44)	50 (37)	47 (35)	27 (20)

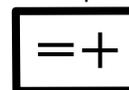
AW: as welded

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

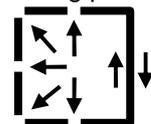
**Packaging:** The same conditions as for solid wire.  
Product should be stored in a dry, enclosed environment, and in its original intact packing

for detailed information please call us

current / polarity



welding position



**Disclaimer:** Whilst all reasonable efforts have been made to ensure the accuracy of the information contained, the information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and any liability incurred from any reliance thereon is expressly disclaimed. Typical data are those obtained when welded and tested in accordance to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Other tests and procedures may produce different results. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application. The selection and use of specific products is solely within the control of, and remains the sole responsibility of the customer. The right to change design and/or specifications without notice is reserved.