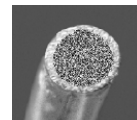




Seamless flux-cored wire

STEIN-MEGAFIL[®] 1100 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 10 kJ/cm.
- Classification:**
- | | |
|----------------|----------------------------|
| EN ISO 18276-A | T 89 4 Mn2Ni1CrMo M M 1 H5 |
| EN ISO 18276-B | T834T15 1MA N4C2M2 H5 |
| AWS ASME 5.28 | ~ E120C-K4 H4 |
| AWS ASME 5.28M | ~ E83C-K4 H4 |

Materials:	DIN	EN	ASTM
TM-pipe steels	to StE 890	to S890QL1	typical A 517 X 120
high-strength fine grain structural steels (low temp)	to StE 960 (StE 1100 up to 12 mm)	to S960QL1 (S1100 up to 12 mm)	

Approvals: TÜV

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

C	Mn	Si	P	S	Cr	Ni	Mo
0,07	1,5	0,5	< 0,015	< 0,015	0,8	2,6	0,6

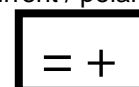
Mechanical properties of the pure weld metal (typical values for mixed gas)

Heat-treatment	R _{p0,2} MPa (ksi)	R _m MPa (ksi)	A5 %	Charpy V Notch [J] (ft.lb)	
				- 20 °C (- 4 °F)	- 40 °C (- 40 °F)
AW	> 960 (139)	980 - 1180 (142 - 171)	> 14	> 55 (41)	> 47 (35)

AW: as welded

Diameters: Ø 1,0 - 1.2 mm (0.04 - 0.045 inch)
Packaging information: see chapter H

current / polarity



welding position

