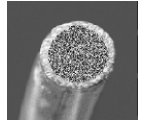




Seamless flux-cored wire

STEIN-MEGAFIL[®] 240 M



Type: Metal cored wire without slag for Ar-CO₂ mix.

Applications: Crane, steel, vessel and apparatus construction. Offshore.

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 50 6 1Ni M M 1 H5
EN ISO 17632-B	T576T15 1MA N1 H5
AWS ASME 5.28	E80C-Ni1 H4
AWS ASME 5.28M	E55C-Ni1 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	S235 - S485	A 258 / A 516 A 662 / A 387
boiler steels	HI, HII, 17Mn4, 19Mn5	P235GH - P485GH	A 738 / A 612
pipe steels	St 35.8, St 45.8 StE 210.7 TM - StE 480.7 TM	P235T1/T2 - P460NL2 L210 - L480MB	A 299
fine grain structural steels	StE 255 - StE 500	S255 - S500 (NL1,2)	
steels to API-standard	X 42 - X 70		

Approvals: TÜV, DB, GL, DNV.

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

C	Mn	Si	P	S	Ni
0,05	1,3	0,7	< 0,015	< 0,015	0,9

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

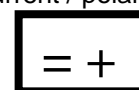
Heat-treatment	R _{eL} MPa (ksi)	R _m MPa (ksi)	A5 %	Charpy V Notch [J] (ft.lb)	
				- 40 °C (- 40 °F)	- 60 °C (- 76 °F)
AW	> 500 (73)	560 - 720 (81 - 104)	> 26	> 80 (59)	> 60 (44)

AW: as welded

Diameters: Ø 1.0 - 1.6 mm (0.04 - 1/16 inch)

Packaging information: see chapter H

current / polarity



welding position

