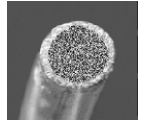




Seamless flux-cored wire

STEIN-MEGAFIL[®] 237 M



- Type:** Metal cored wire without slag for Ar-CO₂ mix.
- Applications:** Construction of containers, boilers, machines and pipe work.
Steam boilers and turbines 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 creep resistant steels and pressure-hydrogen-resistant 2¼Cr1Mo-steels.
- Classification:**
- | | |
|----------------|-------------------|
| EN ISO 17634-A | T CrMo2 M M 1 H5 |
| EN ISO 17634-B | T62T15 1M 2C1M H5 |
| AWS ASME 5.28 | E90C-B3 H4 |
| AWS ASME 5.28M | E62C-B3 H4 |

| Materials: | DIN | EN | ASTM |
|---------------|--|--------------------------|----------------------------|
| Boiler steels | 10CrMo9-10 10CrSiMoV7 12CrMo9-10 etc. | 10CrMo9-10 12CrMo9-10 | typical A 387 Gr. 22 |

Approvals: TÜV

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

| C | Mn | Si | P | S | Cr | Mo |
|------|-----|-----|---------|---------|-----|-----|
| 0,07 | 1,0 | 0,3 | < 0,015 | < 0,015 | 2,3 | 1,1 |

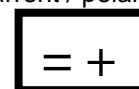
Mechanical properties of the pure weld metal (typical values for mixed gas)

| Heat-treatment | R _{p0,2} MPa (ksi) | R _m MPa (ksi) | A5 % | Charpy V Notch [J] (ft.lb) | |
|----------------|--------------------------------|-----------------------------|---------|----------------------------|------------------|
| | | | | RT | - 20 °C (- 4 °F) |
| SR | > 540 (78) | 620 - 820 (90 - 119) | > 18 | >80 (59) | > 47 (35) |

SR: stress relief annealed 675 - 705°C (1247-1301°F) / 60 min

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

current / polarity



welding position

