

MEGAFIL[®] 235 M



AWS A5.28: E80C-G H4

AWS A5.36: E81T15-M21P4-A1-HA

EN ISO 17634-A: T Mo M M21 1 H5

WELDING POSITIONS:



FEATURES

- Extremely low diffusible hydrogen weld deposit
- Good reignition characteristics
- Ideal for use of short arc and spray arc
- Excellent gap bridging for root welding
- High deposition rate
- Virtually no slag coverage
- Smooth arc characteristic

BENEFITS

- Minimizes risk of hydrogen-induced cracking
- Suitable for robot applications
- Automatic root welding possible
- Root welding without any backing
- Improved efficiency
- Reduced cleaning time
- Easy handling

APPLICATIONS

- Automatic and mechanized welding
- Steel structures
- Pipelines
- Non-alloy and fine grain steels
- Vessels (Mo steels up to 500 °C (932° F))
- General fabrication
- Single and multi-pass welding

WIRE TYPE

SHIELDING GAS

TYPE OF CURRENT

STANDARD DIAMETERS

TYPICAL DIFFUSIBLE HYDROGEN*

RE-DRYING

STORAGE

Gas shielded metal-cored wire

75-85% Argon (Ar)/Balance Carbon Dioxide (CO₂)

Gas Flow 12-18 l/min (25-38 cfm)

Direct Current Electrode Positive (DCEP)

Ø 1.0 - 1.6 mm (0.039 - 1/16")

< 3.0 ml / 100 g; Guaranteed for the total processing time < 4.0 ml / 100 g maximum (AWS Spec)

Not required due to seamless wire design

The same conditions as for solid wire. Product should be stored in a dry, enclosed environment, in its original undamaged packaging

*Measurement technique is the carrier gas method according to AWS and ISO

MATERIALS TO BE WELDED *)

Material	Rel ≤	Material
Shipbuilding steels		A, B, D, AH 32 - EH 36
Unalloyed structural steels	355 MPa	S185 - S355, A 106 Gr.B, A 333 Gr.6
Boiler steels	355 MPa	P235GH - P355GH, 16Mo3
Pipe steels	460 MPa	P235T1/T2 - P460NL2; L210 - L445MB
Fine grain structural steels	460 MPa	S235 - S460QL1
Steels to API-standard	460 MPa	X42 - X70

*) The specified base materials are not complete and should only be seen as examples. The selection of the appropriate combination of steel and welding consumable should follow the specific mechanical strength and toughness requirements.

ALL WELD METAL CHEMISTRY (%) (typical values for mixed gas 82% Ar / 18% CO₂)

Element	Value (%)	Element	Value (%)
Carbon (C)	0.07	Nickel (Ni)	-
Manganese (Mn)	1.1	Molybdenum (Mo)	0.5
Silicon (Si)	0.7	Chromium (Cr)	-
Sulphur (S)	0.015		
Phosphorus (P)	0.015		

ALL WELD METAL MECHANICAL PROPERTIES (for mixed gas 82% Ar / 18% CO₂)

Mechanical tests	Typical values MPa (ksi)	ISO Specification MPa (ksi)
Tensile Strength Rm	600 (87)	550 - 690 (80 - 100)
Yield strength Rp0.2	520 (75)	>470 (68)
Expansion A5	26%	22%

The specified values apply to the as-welded and stress-relieved condition (600 °C / 60 min)

CHARPY V-NOTCH IMPACT VALUES (for mixed gas 82% Ar / 18% CO₂)

Mechanical Tests	Typical values [J] (ft.lbf)	ISO Specification [J] (ft.lbf)
-20° C	120 (89)	> 47 (35)
-40° C	100 (74)	> 47 (35)

The specified values apply to the as-welded and stress-relieved condition (600 °C / 60 min)

APPROVALS: TÜV, DB

Please contact the manufacturer to learn the present scope of approvals