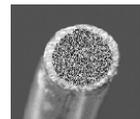




Seamless metal-cored wire for MAG joint welding

MEGAFIL[®] 236 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 CrMo-steels up to 550 °C (1022°F).
- Classification:** EN ISO 17634-A T CrMo1 M M 1 H5
EN ISO 17634-B T55T15 1M 1CM H5
AWS ASME 5.28 E80C-B2 H4
AWS ASME 5.28M E55C-B2 H4

The ASME classification is carried out on the basis of a weld metal according to ISO standards

Materials:	EN	ASTM
Boiler steels	13CrMo4-5	typical A 387 Gr. 11
Cast steels	G17CrMo5-5 G22CrMo5-4	
similarly alloyed heat treatable steels similarly alloyed cementation and nitrided steels		

Approvals: TÜV

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

C	Mn	Si	P	S	Cr	Mo
0,05	1,0	0,3	0,015	0,015	1,1	0,5

Mechanical properties of the pure weld metal (typical values for mixed gas M21)

PWHT	R _{p0,2} MPa (ksi)	R _m MPa (ksi)	A5 %	Charpy V Notch [J] (ft.lb)		
				RT	- 20 °C (- 4 °F)	- 40 °C (- 40 °F)
SR	> 470 (68)	550 - 740 (80 - 107)	20	80 (59)	47 (35)	27 (20)

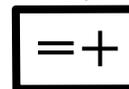
SR: stress relief annealed 675 - 705°C (1247-1301°F) / 60 min

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

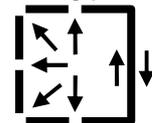
Packaging: The same conditions as for solid wire.
Product should be stored in a dry, enclosed environment, and in its original intact packing

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.