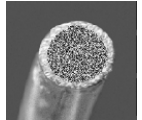




Seamless flux-cored wire for MAG joint welding

MEGAFIL[®] 716 R



Type: Micro-alloy rutile flux-cored wire with rapidly solidifying slag for CO₂ and Ar-CO₂ mix.

Applications: Steel and vessel construction, mechanical engineering and pipe work, shipbuilding. Offshore. Special applications.

Properties: Excellent weld puddle manipulation, superior out-of-position welding. Using temperature up to - 60 °C (- 76 °F). Particularly suited for MAG orbital welding applications and all-position welding on ceramic backing. Low spatter loss, easy slag removal.

Classification:	EN ISO 17632-A	T 46 6 P M 1 H5	T 46 4 P C 1 H5
	EN ISO 17632-B	T556T1 1MA H5	T554T1 1CA H5
	AWS ASME 5.20	E71T-1M-J H4	E71T-1C H4
		E71T-9M-J H4	E71T-9C H4
	AWS ASME 5.20M	E491T-1M-J H4	E491T-1C H4
		E491T-9M-J H4	E491T-9C H4

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

Materials:	EN	ASTM
shipbuilding steels	A, B, D, AH 32 - EH 36	typical A 258 / A 516 A 662 / A 387 A 738 / A 612 A 299
unalloyed structural steels	S185 - S355	
boiler steels	P235GH - P355GH	
pipe steels	P235T1/T2 - P460NL2 L210 - L445MB	
fine grain structural steels	S235 - S460QL1	
steels to API-standard	X 42 - X 60	

Approvals: TÜV, DB, GL in process, DNV in process

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

C	Mn	Si	P	S	Ni
0,05	1,3	0,5	0,015	0,015	0,2

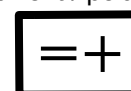
Mechanical properties of the pure weld metal (typical values for mixed gas M21)

PWHT	R_{p0,2} MPa (ksi)	R_m MPa (ksi)	A5 %	Charpy V Notch [J] (ft.lb)		
				- 40 °C (- 40 °F) M21	- 60 °C (- 76 °F) C1	- 60 °C (- 76 °F) M21
AW	> 460 (67)	550 - 670 (80 - 97)	22	70 (52)	50 (37)	60 (44)

AW: as welded

Diameters: Ø 1.2 mm (0.045 inch)
Packaging information: see chapter H

current / polarity



welding position

