



MAXFIL-12R



Codification :

AWS SFA 5.20	E71T1-C, E71T9-C
EN ISO 17632-B	T492T1-1CA-K
IS 15769:2008	ET531RC9H5

Characteristics & Applications :

Maxfil-12R is an all-position mild steel flux cored wire designed for optimum performance on varied Voltage & Current range when using 100% CO₂ & Mix gas (Ar+CO₂) shielding. The wire is characterized with smooth metal transfer, uniform welding even pipe welding in 5G, 6G position, vertical-up position stringer beads and easy slag removal. Filler contour is flat to slightly convex with equal leg lengths and uniform sidewall wetting. Weld metal will give excellent toughness property up to -46°C in As-Welded condition and is of radiographic quality

Maxfil-12R is designed for single and multi-pass welding of low and medium carbon steels like; SA-36, A/B/C/D grades of SA-283, A/B/C grades of SA-285, A/B grades of SA-414, etc.

Typical Chemical Composition of All Weld Metal (%):

Element	C	Mn	Si	P	S
Typical	0.08	1.40	0.50	0.015	0.015

Typical Mechanical Properties Of All Weld Metal :

Properties	UTS (MPa)	YS (MPa)	%EI (L=4d)	CVN Impact Strength (J)	
				-20°C	-30°C
Typical	550	480	28	75	55

Welding Positions :



Current And Packing Data : DC (+)

Dia (mm)	Horizontal/Flat		Vertical Up		Overhead	
	Volt(V)	Current(A)	Volt(V)	Current(A)	Volt(V)	Current(A)
1.2	23-30	160-260	22-26	150-220	23-26	150-220
1.6	25-34	180-300	21-27	180-250	22-27	150-230

Approvals : CE, IBR, BIS, RDSO, IRS, BV, DNV, ABS, EIL.

Shielding Gas : 100% CO₂ & Mixture of Ar-CO₂ at flow rate 15-20LPM.

Packing Data:

Standard Size : Diameter 1.2mm, 1.6mm. Other diameter on request.

Quantity : Supplied approximately 15Kgs in a plastic spool. Each spool is sealed in an air tight polythene bag and then packed in a corrugated box. Also Available in Vacuum Packing on demand.