



MAXFIL-41R

Basic Type Flux Cored Wire

CODIFICATION: AWS/SFA 5.29 EN ISO 17632-B
E91T1-B3C T57ZT1-1CA-G

CHARACTERISTICS AND APPLICATIONS:

Maxfil-41R is an all position low alloy steel flux cored wire designed to deposit approximately 2.25%Cr-1.0%Mo weld metal. The wire is suitable for positional welding application, results easy slag removal and has excellent welders appeal. The weld bead is smooth & uniform and meets the radiographic requirements.

Maxfil-41R is designed for single and multi-pass welding of similar composition creep resistant steels and equivalent grade steels like: Gr. F22 of SA-182 & and SA-336, Gr. T4/T22 of SA-199, Gr. T22 of SA-213, Gr. WC9 of SA-217, Gr. P22 of SA-335, Gr. FP22 of SA-369, Gr. 22/22L of SA-387, Gr. CP22 of SA-426, Gr. 22 of SA-541, Class 1 of A, B types of SA-542, etc.

CHEMICAL COMPOSITION OF ALL WELD METAL (%):

Element	C	Mn	Si	S	P	Cr	Mo
Range	0.05-0.12	1.25	0.80	0.030	0.030	2.00-2.50	0.90-1.20
Typical	0.068	0.76	0.38	0.012	0.016	2.38	1.05

MECHANICAL PROPERTIES OF ALL WELD METAL:

Property	UTS (Mpa)	YS (Mpa)	%El (L=4d)
Range	620-760	540 Min	17.0 Min
SR : 690°C/1Hr	678	584	20.0

WELDING POSITIONS: H, F, VU, OH

WELDING PARAMETER: DC (+)

Diameter (mm)	HORIZONTAL/FLAT		VERTICAL UP		OVERHEAD	
	Volt, V	Current, A	Volt, V	Current, A	Volt, V	Current, A
1.20	24-28	160-260	20-22	100-160	22-25	100-160
1.60	24-28	180-300	20-22	110-200	22-25	110-200

APPROVALS: CE MARKING

SHIELDING GAS : Carbon Dioxide CO₂ (100%) at flow rate 12-15 litres per minute.

PACKING :

Standard size : 1.20 & 1.60mm. Other diameters may be available 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.