MAXFIL-701G5

Basic Type Flux Cored Wire

CODIFICATION: AWS/SFA 5.29
E70T5-GC

CHARACTERISTICS AND APPLICATIONS:

Maxfil-701G5 is a low alloy steel flux cored wire designed for welding of medium & high tensile strength steel, quenched & tempered steels, etc. where sub-zero impact resistance property of the weld metal is desired. The weld metal is designed for thick plates so that properties are maintained after stress relief heat treatment also. The wire is results optimum performance and radiographic quality weld deposits under CO2 shielding. The weld has excellent bead appearance and easy slag removal.

Maxfil-701G5 is designed for single and multi-pass welding of similar composition steels and equivalent grade steels like; NAXTRA-60/65, Sumiten-610, A/B grades of SA-203, D/E/F/G grades of SA-414, steel grades conforming to SA-455, Gr.60 & Gr.65 steels of SA-515 & SA-516, etc. Based on the composition & plate thickness, preheating & inter-pass temperature shall be maintained.

CHEMICAL COMPOSITION OF ALL WELD METAL (%):

Element	C	Mn	Si	S	P	Ni	Mo
Typical	0.062	1.24	0.44	0.015	0.022	0.65	0.25

MECHANICAL PROPERTIES OF ALL WELD METAL:

Property	UTS (Mpa)	YS (Mpa)	%El (L=4d)	CVN Impact (Joules) at -46°C
SR:620°C/2Hrs	562	518	24.0	38

WELDING POSITIONS: H, F, VU

WELDING PARAMETER: DC (+)

Diameter	HORIZONTAL		FLAT		VERTICAL UP	
(mm)	Volt, V	Current, A	Volt, V	Current, A	Volt, V	Current, A
1.20	24-28	160-260	24-28	160-260	18-22	100-160
1.60	24-28	180-300	24-28	180-300	18-22	110-200

SHIELDING GAS : Carbon Dioxide CO_2 (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.