# MAXFIL-70A1

Basic Type Flux Cored Wire

CODIFICATION: AWS/SFA 5.29 E70T5-A1C | EN ISO 17632-B T493T5-0CP 2M3

## CHARACTERISTICS AND APPLICATIONS:

Maxfil-70 A1 is a low alloy steel flux cored wire designed for welding of 0.5% Molybdenum and 1% Chromium and 0.5% Molybdenum steels. The wire gives optimum performance under CO2 shielding with radiographic quality weld deposits. The wire produces thin & friable slag covering with shiny bead appearance.

Maxfil-70 A1 is designed for single and multi-pass welding of similar composition steels and equivalent grade steels like; Gr. F1 of SA-182 and SA-336, Gr. A of SA-204, Gr. T1/T1a/T1b of SA-209, Gr. WC1 of SA-217, Gr. A of SA-302, Gr. P1 of SA-335, Class 1 of A grade of SA-533, etc.

## CHEMICAL COMPOSITION OF ALL WELD METAL (%):

| Element | C | Mn | Si | S | P | Mo |
|---|---|---|---|---|---|---|
| Range | 0.12 | 1.25 | 0.80 | 0.030 | 0.030 | 0.40-0.65 |
| Typical | 0.060 | 1.18 | 0.45 | 0.012 | 0.018 | 0.52 |

## MECHANICAL PROPERTIES OF ALL WELD METAL:

| Property | UTS (Mpa) | YS (Mpa) | %El (L=4d) | CVN Impact (Joules) at -30°C |
|---|---|---|---|---|
| Range | 490-620 | 400 Min | 20.0 Min | 27 Min |
| SR: 620°C/1Hr | 548 | 460 | 25.0 | 65 |

## 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 |

APPROVALS: CE MARKING

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.