



MAXFIL MC-42B

Low Alloy Steel Metal Cored Wire

CODIFICATION: AWS/SFA 5.36M
 E11T15- M21A5-K4

CHARACTERISTICS AND APPLICATIONS:

Maxfil MC-42B is a low alloy steel flux cored wire designed for welding of high strength fine grained quenched & tempered steels to meet sub-zero impact resistance property down to -50°C. The wire gives optimum performance under Ar + CO₂ shielding and deposits radiographic quality weld metal. The deposited weld metal is virtually free from slag covering and thus reduces post welding cleaning time.

Maxfil MC-42B is designed for single and multi-pass welding of similar composition steels and equivalent grade steels like; HY-80, NAXTRA-60/65, T-1, A/B grades of SA-203, A/B/C grades of SA-662, B/C grades of SA-737, etc. This wire is used for fabrication of crane plate, earth moving equipments and similar high strength applications, etc.

CHEMICAL COMPOSITION OF ALL WELD METAL (%):

ELEMENTS	C	Mn	Si	S	P	Cr	Ni	Mo	V
RANGE	0.15	1.20-2.25	0.80	0.030	0.030	0.20-0.60	1.75-2.60	0.20-0.65	0.03
TYPICAL	0.050	1.75	0.62	0.008	0.010	0.55	2.37	0.55	0.010

MECHANICAL PROPERTIES OF ALL WELD METAL:

Property	UTS (Mpa)	YS (Mpa)	%EI (L=4d)	CVN Impact (Joules) at -50°C
Range	760-900	680 Min	15.0 Min	27 Min
As Weld	880	767	18.0	34

WELDING POSITIONS: H, F, VU

WELDING PARAMETER: DC (+)

Diameter (mm)	HORIZONTAL		FLAT		VERTICAL UP	
	Volt, V	Current, A	Volt, V	Current, A	Volt, V	Current, A
1.20	32-36	280-350	32-36	280-350	20-24	100-160
1.60	30-34	350-500	30-34	350-500	24-28	150-200

SHIELDING GAS: Argon - Carbon Dioxide CO₂ (80-20%) mixture 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.