

MEGAFIL[®] A 730 M



EN ISO 14700: T Fe1

WELDING POSITIONS:



FEATURES

- Well suited for wear resisting parts subject to impact
- Good reignition characteristics
- Virtually no slag coverage
- Smooth arc characteristic

BENEFITS

- Machinable weld metal
- Hardening possible
- No re-drying
- Suitable for robot applications

APPLICATIONS

- Automatic and mechanized welding
- Railroad frogs
- Transport rollers and wheels
- Rope pulleys
- Wear parts of track vehicles

WIRE TYPE	Gas shielded metal-cored wire
SHIELDING GAS	75-85% Argon (Ar) / Balance Carbon Dioxid (CO ₂); Gas Flow 12-18 l/min (25-38 cfm)
TYPE OF CURRENT	Direct Current Electrode Positive (DCEP)
STANDARD DIAMETERS	Ø 1.2 mm (0.045")
RE-DRYING	Not required due to seamless wire design.
STORAGE	The same conditions as for solid wire. Product should be stored in a dry, enclosed environment, in its original undamaged packaging

WELD METAL ANALYSIS (%) (typical values for mixed gas 82% Ar / 18% CO₂)

	Carbon (C)	0.22	Nickel (Ni)	-
Manganese (Mn)	1.5			
Silicon (Si)	0.6			
Chromium (Cr)	1.3			
Molybdenum (Mo)	-			

HARDNESS OF PURE WELD METAL FROM THE 3rd LAYER (typical values for mixed gas 82% Ar / 18% CO₂)

Hardness Rockwell (HRC)	25 - 35	The achieved hardness as well as the structure of the hardfacing depends on (among others): Base material, welding parameters, working and interpass temperature, heating up, cooling down, number of layers, hardfacing methods and shape of component.
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