MIG MARVAL X12S

Classification

DIN 8555 : MSG 5-GZ-400-R
EN 14700 : S Z Fe7

Material N° : 1.4530

Description & Applications

Solid wire for GMAW for welding and for hardfacing. Product of high purity for welding without micro porosity.

Main applications: Used to weld and to repair parent metals like X1CrNiMoAlTi12-9-2 and others.

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	Ti	Al	Fe
<0.01	0.05	0.02	12.0	9.4	2.0	0.3	0.7	Rem.

All Weld Metal Mechanical Properties

Hardness
~32 HRC

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
MIG =+	0.8 1.0 1.2 1.6	60-100 150-170 150-220 180-270	18-21 25-28 26-28 26-32	EN 439: I1 (Ar+He) 15-18 l/min

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