

MEGAFIL[®] A 750 M



EN ISO 14700: T Z Fe2

WELDING POSITIONS:



FEATURES	BENEFITS	APPLICATIONS
<ul style="list-style-type: none">)] Well suited for wear resisting parts subject to heavy impact)] Good reignition characteristics)] Virtually no slag coverage)] Smooth arc characteristic 	<ul style="list-style-type: none">)] No buffer layer except on materials considered critical)] Machinable weld metal)] Hardening possible)] No re-drying)] Suitable for robot applications 	<ul style="list-style-type: none">)] Automatic and mechanized welding)] Conveyors and transport surfaces)] Tires)] Construction equipment

WIRE TYPE	Gas shielded metal-cored wire
SHIELDING GAS	75-85% Argon (Ar)/Balance Carbon Dioxide (CO ₂); Gas flow 12-18 l/min
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)

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Carbon (C)	0.3	Nickel (Ni)	-
Manganese (Mn)	1.5		
Silicon (Si)	0.4		
Chromium (Cr)	5.5		
Molybdenum (Mo)	0.5		

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

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Hardness Rockwell (HRC)	45 - 55	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.