

MAXFIL-37R

Rutile Type Flux Cored Wire

CODIFICATION:

AWS/SFA 5.29

EN ISO 17632-B

E81T1-Ni1C

T553T1-1CA N2

CHARACTERISTICS AND APPLICATIONS:

Maxfil-37R 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. The wire gives optimum performance under CO₂ shielding and deposits radiographic quality weld metal. The weld has excellent bead appearance and easy slag removal. The wire sets low diffusible hydrogen content (<4ml/100gm) in the weld metal.

Maxfil-37R is designed for single and multi-pass welding of similar composition steels and equivalent grade steels like; A/B grades of SA-203, A/B/C grades of SA-662, B/C grades of SA-737, N-A-XTRA-60/65, etc. This wire is used for heavy fabrication work subjected to dynamic loading, earth moving equipments, off-shore platforms and similar kind of applications, etc.

CHEMICAL COMPOSITION OF ALL WELD METAL (%):

Element	C	Mn	Si	S	P	Cr	Ni	Mo	V	Al
Range	0.12	1.50	0.80	0.03	0.03	0.15	0.80-1.10	0.35	0.05	1.8
Typical	0.052	1.26	0.45	0.014	0.018	0.10	1.00	0.25	0.001	0.020

MECHANICAL PROPERTIES OF ALL WELD METAL:

Property	UTS (Mpa)	YS (Mpa)	%El (L=4d)	CVN Impact (Joules) at -30°C
Range	550-690	470 Min	19 Min	27 Min
Typical	625	516	22.0	55

WELDING POSITIONS: H, F, VU, OH

WELDING PARAMETER: DC (+)

Diameter (mm)	HORIZONTAL		FLAT	VERTICAL UP		Current, A
	Volt, V	Current, A	Volt, V	Current, A	Volt, V	
1.20	24-28	160-260	20-22	100-160	22-25	100-160
1.60	24-28	180-300	20-22	110-200	22-25	110-200

APPROVALS: CE MARKING

SHIELDING GAS: Argon - Carbon Dioxide CO₂ (80:20%) 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 airtight polythene bag and then packed in a corrugated box.

AUTHORISED DISTRIBUTOR - SALES & SERVICE

Head Office: Marn Burn Business Park | Suite No 900A | Block- BP | Salt Lake | Sector - V | Kolkata - 700091 | West Bengal | India

Regd. Office: 161/1 Mahatma Gandhi Road | Suite 83A | 3rd Floor | Kolkata - 700007 | West Bengal | India

info@crossmarketing.co.in | lakhotia.ravi@gmail.com | +91 89816 20042

<https://crossmarketing.co.in/>