

MAXFIL-12R

Rutile Type Flux Cored Wire

CODIFICATION: AWS/SFA 5.20 EN ISO 17632-B
E71T-1C T492T1-1CA-K

CHARACTERISTICS AND APPLICATIONS:

Maxfil-12R is an all position mild steel flux cored wire designed for optimum performance when using 100% CO₂ shielding. The wire is characterized with smooth metal transfer, uniform welding even on vertical-up stringer beads and easy slag removal. Filler contour is flat to slightly convex with equal leg lengths and uniform sidewall wetting. Weld metal is of radiographic quality.

Maxfil-12R is designed for single and multi-pass welding of low and medium carbon steels like; SA-36, A/B/C/D grades of SA-283, A/B/C grades of SA-285, A/B grades of SA-414, etc.

CHEMICAL COMPOSITION OF ALL WELD METAL (%):

ELEMENTS	C	Mn	Si	S	P	Cr	Ni	Mo	V	Cu
RANGE	0.12	1.75	0.90	0.03	0.03	0.20	0.50	0.30	0.08	0.35
TYPICAL	0.05	1.21	0.43	0.015	0.021	0.020	0.015	0.010	0.010	0.005

MECHANICAL PROPERTIES OF ALL WELD METAL:

Property	UTS (Mpa)	YS (Mpa)	%El (L=4d)	CVN Impact (Joules) at - 20°C
Range	490-670	390 Min	22 Min	27 Min
Typical	530	440	28.0	55

WELDING POSITIONS: H, F, VU, OH

WELDING PARAMETER: DC (+)

Diameter (mm)	HORIZONTAL/FLAT		VERTICAL UP		OVER HEAD	
	Volt, V	Current, A	Volt, V	Current, A	Volt, V	Current, A
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, BV, IRS

SHIELDING GAS : Carbon Dioxide Co₂ (100%) 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.

AUTHORISED DISTRIBUTOR - SALES & SERVICE

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