

MW-15CDV6 GTAW/GMAW Welding Wire

Suitable to weld steels such as 15CrMoV6, 25CrMo4, 35CrMo4 and 20CrMo12, 15CDV6, 1.7734

Product of high purity for welding without micro porosity. Also used for hard facing of tool steels - copper coated.

Quality product manufactured in the UK since 2006 .

Available in a wide range of diameters in GTAW starting from 0.8mm - 2.4mm. Also available in GMAW upon request.

CLASSIFICATION

Material No 1.7734

AIR 9117 15CDV6 (LN 9425)

EN 4334

15CrMnMoV5-4-9-3

SHIELDING GAS

Pure Argon

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS %

C	Mn	Fe	P	S	Si	Cr	V	Mo
0.14	1.0	Rem	<0.02	<0.02	0.15	1.4	0.25	0.25

TYPICAL HEAT TREATMENT ¹

Preheat, interpass temperature and PWHT will be dependant on application and base material

TYPICAL ALL WELD MECHANICAL PROPERTIES:²

As Welded

Dependant on PWHT.

0.2% proof stress, Rp0.3%: ~900MPa

Tensile strength, Rm: ~1200MPa

Elongation, 4d/5d: ~10%

SIZES AVAILABLE

MIG 0.8mm 1.0mm 1.2mm

TIG 0.8mm 1.2mm 1.6mm 2.0mm 2.4mm

NOTES

(1) Application codes and project specifications should always be referred to for specific requirements

(2) Actual mechanical properties will be dependant on specific welding procedure (including shielding gas, flux, PWHT etc) and should always be confirmed by approval of an appropriate welding procedure.