



DRAHTZUG STEIN

wire & welding

STEIN-MEGAFIL 713R

Type	Micro-alloy rutile flux-cored wire with rapidly solidifying slag for CO ₂ and Ar-CO ₂ mix
Applications	Shipbuilding, steel and pressure vessel construction, mechanical engineering and pipe work.
Properties	Excellent weld puddle manipulation, superior allposition welding also at higher currents. Using temperature up to - 40 °C. Particularly suited for MAG-orbital welding and allposition welding on ceramic backing. Low spatter loss, easy slag removal.

Classification

EN 758	T462PC1H5/T464PM1H5
DIN 8559	SGR1CY4643/SGR1M21Y4643
SFA-5.20	E71T-1

Approvals

TÜV, DB ,GL, Controlas, BV, LR, DNV, RINA, PRS, FORCE, ABS,CWB

Materials	DIN
Shipbuilding steels	A, B, D, E, AH 32 - EH 36
Unalloyed structural steel	St 33, St 37-2 bis St 52-3
Boiler steels	H I, H II, 17 Mn 4, 19 Mn 5
Pipe steels	St 35.8, St 45.8 StE 210.7 TM - StE 480.7 TM
Fine grain structural steels	StE 255 bis StE 460
Steels to API-standard	X 42 - X 70

Materials	EN
Shipbuilding steels	A, B, D, E, AH 32 - EH 36
Unalloyed structural steel	S 185, S235 - S355
Boiler steels	P 235 GH, P 265 GH,
Pipe steels	P 235 T1/T2 - P 355 N
Fine grain structural steels	S255-S460
Steels to API-standard	X 42 - X 70

Materials	ASTM
Shipbuilding steels	A 131
Unalloyed structural steel	A 106 / A 515 / A714
Boiler steels	A 283 / A 285 / A 414 / A 662 / A 372
Pipe steels	A 369 / A 210 / A 106
Fine grain structural steels	S255-S460
Steels to API-standard	X 42 - X 70

Weld metal analysis										
Welding flux	C	Mn	Si	P	S	Cr	Ni	Mo	V	Cu
	0,05	1,3	0,5	<0,015	<0,015					
Welding flux	Nb	W	B	As	Sn	Sb	Al			

Mechanical Properties			
Heat treatment	RP02	Rm	A5
AW: as welded	460 (67)	550 (80) to 650 (94)	22

Hardness value	
HRC hardness Rockwell	to

Charpy V Notch				
	RT	-20 °C (-4 °F)	-40 °C (-40 °F)	
AW		>44	>44	

Current type / Polarity


Welding position
