



# MIG 15/5CU

## Classification

AMS : 5826

ISO 14343-A : G Z 15 5 Cu

## Description & Applications

Solid wire for GMAW of stainless steels with similar chemical compositions like 15-5PH.

**Main applications:** Aerospace, marine pump and turbine, Repairing of turbine discs, turbine blades.

## Typical Chemical Composition ( % )

	C	Si	Mn	Cr	Ni	Mo	Cu	Nb
Min	0.025		0.25	14.40	4.75		3.00	5Xc
Max	0.50	0.60	0.75	15.30	5.50	0.30	3.50	0.40
Type	0.04	0.40	0.50	15.0	5.2	0.01	3.2	0.30

  

	Al	P	S	N	Ta	O	H
Min							
Max	0.025	0.020	0.010	0.040	0.05	0.01	0.0006
Type	0.005	0.005	0.003	0.002	0.01	0.005	0.0001

## All Weld Metal Mechanical Properties\*

	R <sub>e</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	KV ( J )
Min				-
Max				-
Type	-	-	-	-

\* Depending of the PWHT performed

## Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Current (A)	Voltage (V)	
GMAW = +	0.8	70 - 180	18 - 26	ISO 14175: M12 (Ar+0.5-5%CO <sub>2</sub> ) M13 (Ar+0.5-3%O <sub>2</sub> ) 15-20 l/min
	1.0	80 - 220	18 - 28	
	1.2	150 - 320	22 - 32	
	1.6	220 - 380	24 - 34	

FT En-MN62-190613

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[www.fsh-welding.com](http://www.fsh-welding.com) - [info@fsh-welding.fr](mailto:info@fsh-welding.fr)