



# MIG BMS

## Classification

AIR 9117 : 8CD12

## Description & Applications

Solid wire for GMAW of steels such as 15CrMoV6, 25CrMo4, 35CrMo4, 20CrMo12... Product of high purity for welding without micro porosity. It is also used for hardfacing of tool steels.

Available in copper coated or bare form.

## Typical Chemical Composition ( % )

C	Si	Mn	Cr	Mo	P	S	Fe
0.06	0.7	1.1	2.7	1.0	<0.015	<0.015	Rem.

## All Weld Metal Mechanical Properties

R <sub>e</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> ( % )	Hardness (as welded)
440	570	24	36 HRC
After PWHT 730°C/2h			

## Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
MIG = +	0.8	60-100	18-21	EN 439: M21 (Ar/CO <sub>2</sub> ) 12-15 l/min
	1.0	150-170	25-28	
	1.2	150-220	26-28	
	1.6	190-300	26-32	

Preheating of work-piece at about 250°C. Post weld heat treatment: 730°C/2h/

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