



MIG F66S

Classification

AIR 9117 : 25CD4

Description & Applications

Solid wire for GMAW to weld steels such as 1.7214; 25CrMo4, 35CrMo4, 20CrMo12... Product of high purity for welding without micro porosity. It is also used for hardfacing of tool steels.

Typical Chemical Composition (%)

C	Si	Mn	Cr	Mo	Ni	P	S	Fe
0.23	0.2	0.7	1.2	0.2	0.15	<0.02	<0.02	Rem.

All Weld Metal Mechanical Properties

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
750	880-1080	12	46 HRC

Depending on heat treatment

Welding Current & Instructions

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

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