



MIG SCVS

Classification

AIR 9117 : 15CDV6

Description & Applications

Solid wire for GMAW to weld 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 copper and no coated.

Typical Chemical Composition (%)

C	Si	Mn	Cr	Mo	V	P	S	Fe
0.14	0.15	1.0	1.4	0.9	0.25	<0.02	<0.02	Rem.

All Weld Metal Mechanical Properties

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
930	1080-1280	10	42 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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