



Ferromaxx[®] 7

For faster, cleaner welding of steel

Purpose-designed for MAG welding of carbon, carbon manganese and low-alloy steels, the Ferromaxx[®] gases give superb weld quality and excellent penetration, together with minimal spatter and low fume levels.

The thin and medium steel specialist

Ferromaxx[®] 7 is a ternary mixture (of argon, CO₂ and oxygen) specially formulated to weld carbon steels and galvanised and electrogalvanised sheet steel.

- Improves weld quality and reduces rejects, excellent weld control, particularly at low voltages on thin and medium thickness materials (up to 10mm thick) and for positional welding.
- Low spatter levels cut post-weld cleaning times.
Excellent pulsed arc characteristics



Approved welding procedure Ferromaxx® 7

Manufacturer:	Air Products PLC Air Products Ireland Ltd
Main welding process:	MAG 135
Root welding process:	n/a
Joint type:	Fillet

Joint design

Preparation of parts	Sandblasting and solvent cleaning
Parent material and specifications	BS 970: Part 3 Grade 080A15
Composition	C - 0.13 / 0.18% Si - 0.10 / 0.40% Mn - 0.60 / 1.0% P - 0.050% max. S - 0.050% max.
Material thickness	6 mm
Outside diameter	n/a
Welding position	Flat (PB)

Welding details

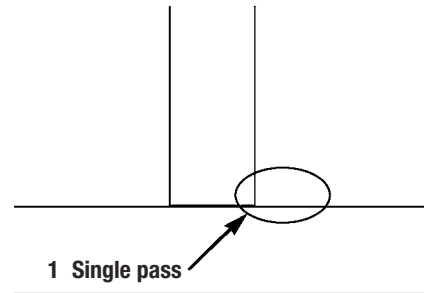
Run	Process	Diameter of filler metal (mm)	Current (A)	Voltage (V)	Type of Wire feed Current & Polarity	Wire feed Speed (m/min)	Travel Speed (mm/min)	Heat Input (KJ)
1	MAG	1.0	208	23.5	DC+	10	330	0.8
2								
3								
4								
5								
6								

Filler metal and specification	AWS-A5.18 ER 70S-6 (SG3Si)
Filler metal composition	Carbon steel C - 0.12% max. - Si - 0.70 / 1.2% Mn - 0.9 / 1.6% - P - 0.040% max. S - 0.040% max. Cu - 0.040% max.
Shielding gas	Ferromaxx® 7
Classification of shielding gas	EN 439 – M 24
Gas flow rate	
– Shield gas	15 l/min
– Purge gas	n/a
TIG electrode type	n/a
Underside protection	n/a
Preheat temperature	Ambient
Interpass temperature	n/a
Heat treatment	n/a
Stand off distance	15 mm

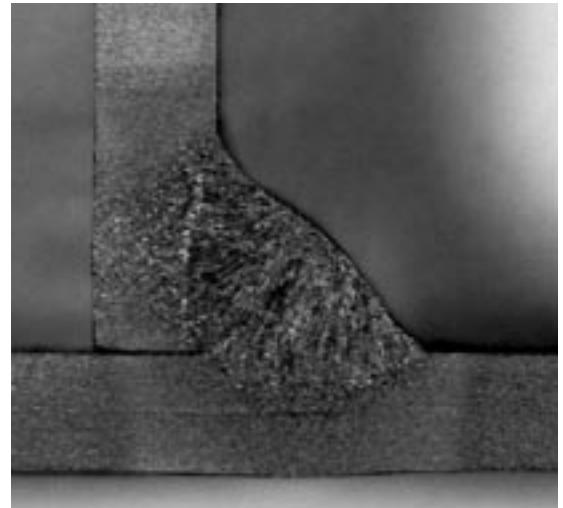
Torch angle	15° in the direction of welding
Nozzle bore diameter	20 mm

*n/a: not applicable

Welding sequence



Macrography



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