

PRODUCT DATA SHEET

Afrox Coremax 7I Plus



Coremax 7I Plus is a gas shielded flux cored wire for welding carbon manganese steels, having a tensile strength of up to 620 MPa and where impact properties of sub-zero may be required. It has low spatter level and the slag is easy to remove. The wire is recommended for single and multi-pass welding in all positions using a 75% Ar, 25% CO₂ argon based mixed gas (Afrox Fluxshield®) or CO₂.

Classifications

AWS	A5.20	E71T-1M
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Approvals

Det Norske Veritas

Bureau Veritas

Typical Chemical Analysis (All weld metal)

% Carbon	0,04	% Sulphur	0,01
% Manganese	1,32	% Phosphorous	0,02
% Silicon	0,42		

Typical Mechanical Properties (All weld metal using CO₂ gas)

Yield Strength	540 MPa
Tensile Strength	580 MPa
% Elongation on 5d	28
Charpy V-Notch at -18°C	65 J

Welding Data

(DC+) Shielding Gas: 75% Ar/25% CO₂ or CO₂

Diameter (mm)	Position	Current		Deposition Rates (kg/h)	Electrode Stick Out (mm)
		Amps (A)	Volts (V)		
1,2	Flat/horizontal	260	27	4,1	12
1,2	Vertical-up/overhead	170 - 220	23 - 25	2,0 - 3,4	12
1,6	Flat	360	29	5,5	25
1,6	Horizontal	280	26	3,6	25
1,6	Vertical-up/overhead	215 - 245	24 - 25	2,6 - 3,0	25

Packing Data

Diameter (mm)	Spool Mass (kg)	Item Number
1,2	15,0	W081230
1,6	15,0	W081231

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