



MIG 15CDV6

Classification

AIR 9117 : 15CDV6

EN 4334 : 15CrMnMoV5-4-9-3

Description & Applications

Solid wire for gas (Ar + CO₂) metal arc welding of low alloy with Chromium, Molybdenum and Vanadium alloyed steels like 15CrMoV6 and steels with similar chemical composition. Product of high purity. Weld deposit exempt of micro-porosity. Also used for build up of tool steels. Product **WITHOUT** copper coated.

Main applications: Aeronautic industry

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Mo	V	P	S	P+S
Min	0.12		0.80	1.25	0.80	0.20			
Max	0.15	0.20	1.10	1.50	1.00	0.30	0.020	0.015	0.040
Type	0.14	0.15	1.0	1.4	0.90	0.25	0.003	0.001	<0.040

All Weld Metal Mechanical Properties*

	Re (MPa)	R _m (MPa)	A ₅ (%)	Hardness
Min	-	-	-	
Max				
Type	930	1080-1280	10	~42 HRC

* Depending on PWHT

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Current (A)	Voltage (V)	
GMAW = +	1.0	150 - 170	25 - 28	ISO 14175: M21 (Ar/CO ₂) 18 l/min
	1.2	150 - 220	26 - 28	
	1.6	190 - 300	26 - 32	

FT En-ME10-230615

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