



MIG F66S

Classification

AIR 9117 : 25CD4

EN 4331 : 25CrMnMo4-2-2

Description & Applications

Solid wire for gas (Ar + CO₂) metal arc welding of low alloy with Chromium and Molybden alloyed steels like 15CrMoV6 and steels with similar chemical composition. Also used for build up of tool steels. Product **WITHOUT** copper coated.

Main applications: Aeronautic industry

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	P	S	P+S
Min	0.21		0.40	0.80		0.17			
Max	0.25	0.25	0.80	1.20	0.30	0.30	0.020	0.020	0.040
Type	0.23	0.20	0.70	1.2	0.15	0.20	0.010	0.015	<0.040

All Weld Metal Mechanical Properties*

	R _e (MPa)	R _m (MPa)	A ₅ (%)	Hardness
Min	-	-	-	
Max				
Type	750	880-1080	12	~46 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-ME02-191113

Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.